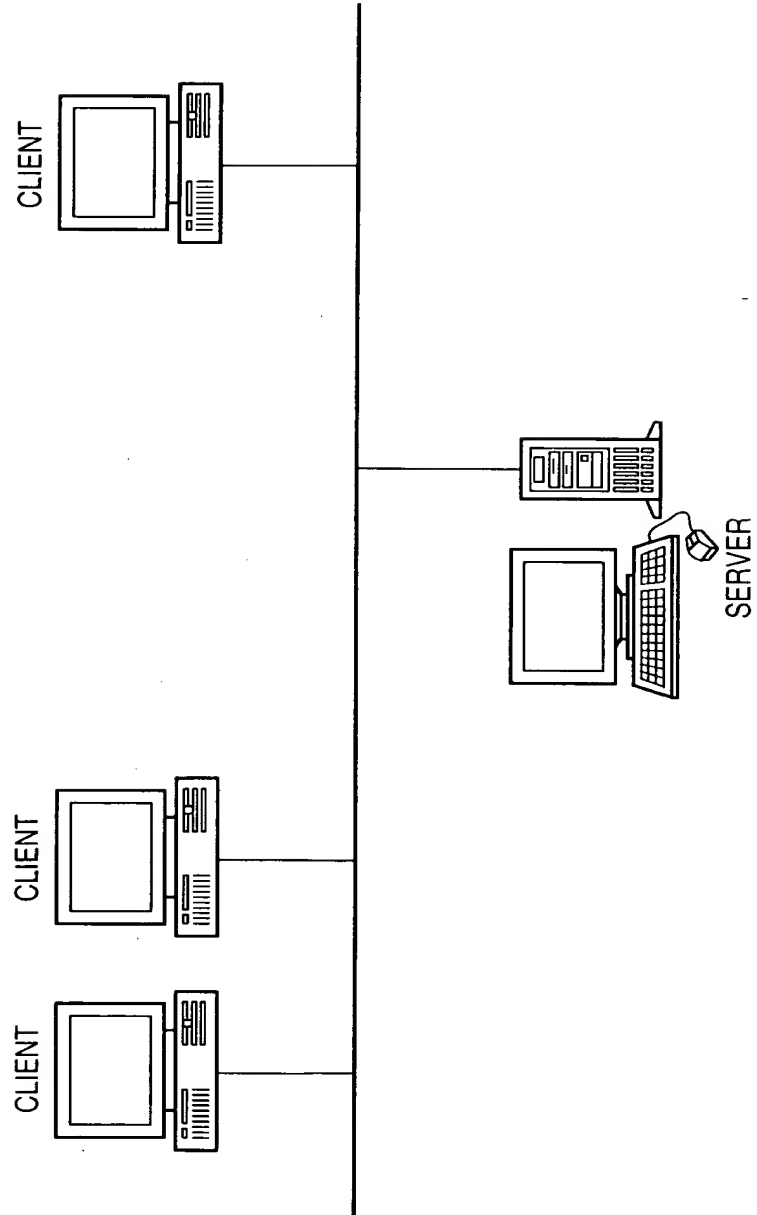
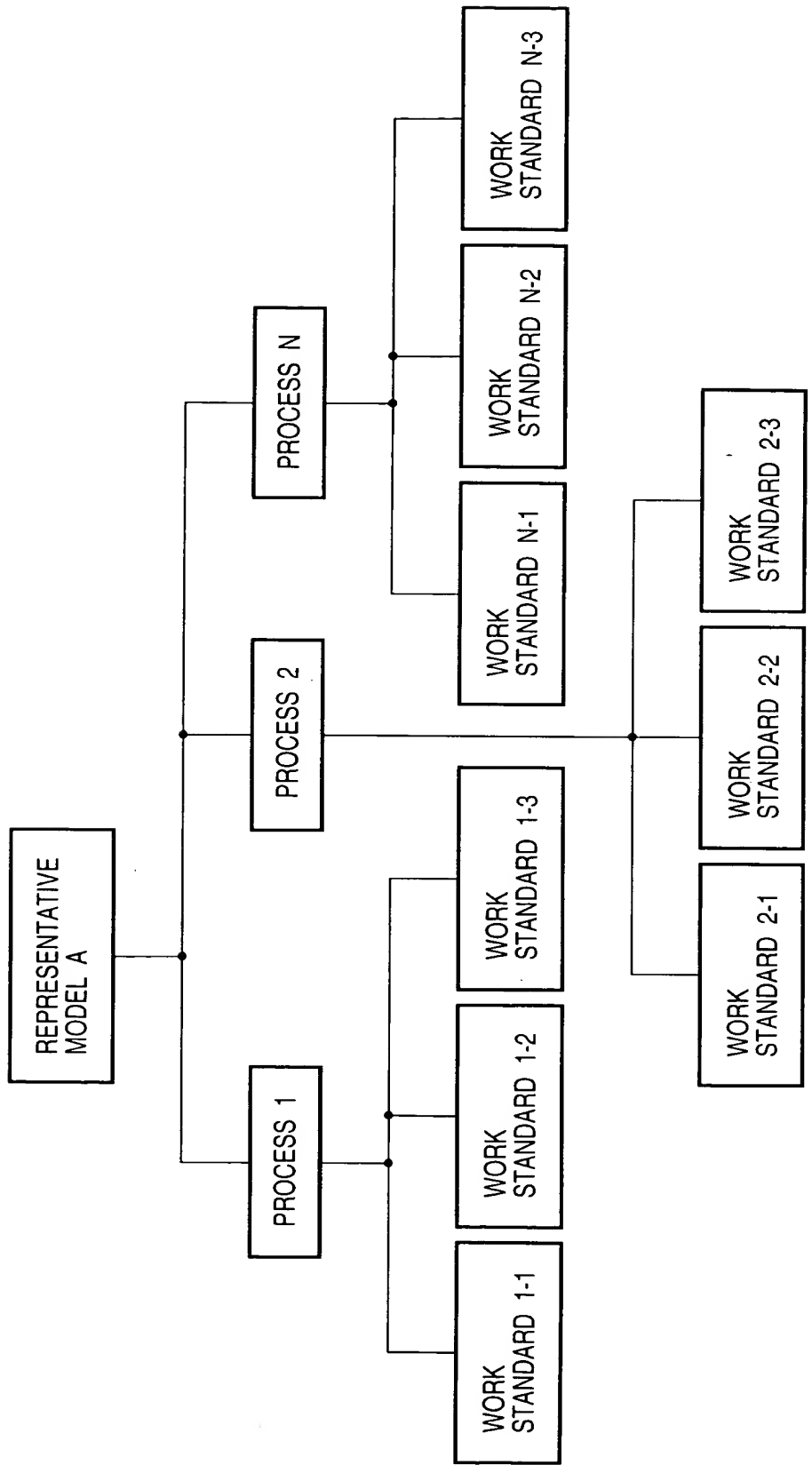


FIG. 1



U.S. GOVERNMENT PRINTING OFFICE: 1967 O 344-000

FIG. 2



# FIG. 3

302

WORK STANDARD 01 CREATION 300

APPLIED	
---------	--

PART NUMBER	PART NAME	QUANTITY	PART NUMBER	PART NAME	QUANTITY
303	304	305			

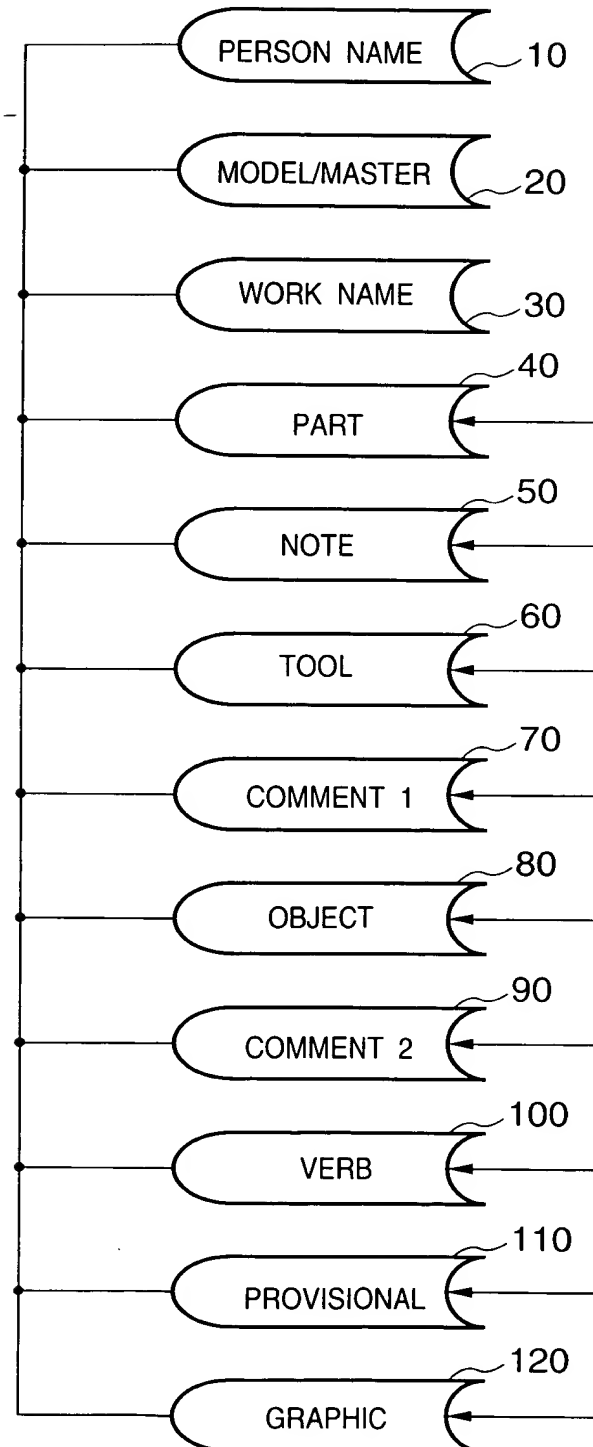
TOOL / TREATMENT DEVICE / AUXILIARY MATERIAL		QUANTITY	CHECK ETC.
306		307	308

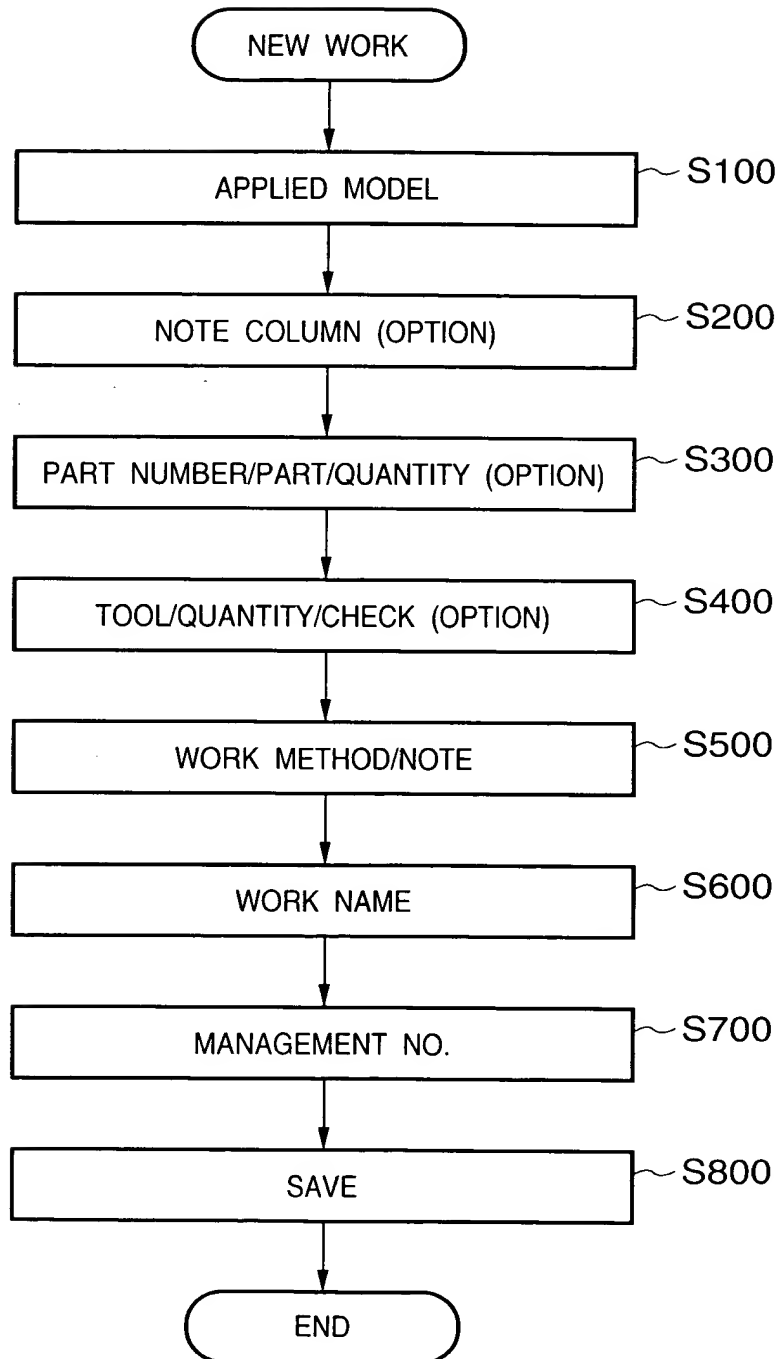
No.	WORK PROCEDURE	No.	NOTE / STANDARD ETC.
	310		

REVISION NUMBER	CONTENTS OF REVISION	DATE	PERSON IN CHARGE	APPROVE	WORK NAME
01	CREATED	1997/09/25			
					MANAGEMENT NO.

**FIG. 4**

## STRUCTURE OF MASTER FILE



**FIG. 5**

**FIG. 6**

SELECTION OF APPLIED MODEL
LIST OF APPLIED MODELS
BJC-4200 SYSTEM
BJC-420J
BJC-420J (BLACK)
BJC-4300
BJC-430J
BJC-4200LX
A250 II Q
BJC-4200
OK
CANCEL

FIG. 7

WORK STANDARD 01 CREATION				<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	
APPLIED		BJC-420J BJC-420J(BLACK) BJC-430J			
PART NUMBER	PART NAME	QUANTITY	PART NUMBER	PART NAME	QUANTITY

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**FIG. 8**

PART NUMBER	PART NAME	QUANTITY	PART NUMBER
PART			
000 - 0000 - 001	PART 001	▲	
000 - 0000 - 002	PART 002		
000 - 0000 - 003	PART 003		
001 - 0000 - 001	PART 101	▼	
001 - 0000 - 002	PART 102		
111 - 1111 - 001	PART 001		
A01 - 1234 - 001	TEST PART 0001		



## FIG. 9

• WORK NAME

GE \_\_\_\_

• CANDIDATES

原稿(GENKO)ガラス保護紙セット(SET ORIGINAL GLASS PROTECTIVE SHEET)

現像(GENZOU)レール戻しバネ掛け(HOOK DEVELOPING RAIL RETURN SPRING)

現像(GENZOU)レール戻しバネ掛け(後)(HOOK DEVELOPING RAIL RETURN SPRING(AFTER))

原稿(GENKOU)台ガラスセット(SET ORIGINAL GLASS TABLE)

原稿(GENKOU)台保護紙セット(SET ORIGINAL TABLE PROTECTIVE SHEET)

現像機(GENZOUKI)トナーなしチェック(CHECK NO TONER IN DEVELOPER)

現像機(GENZOUKI)エラーチェック(CHECK ERROR IN DEVELOPER)

現像機(GENZOUKI)ロック(LOCK DEVELOPER)

## FIG. 10

• WORK NAME

現像(GENZOU) \_\_\_\_

• CANDIDATES

現像(GENZOU)レール戻しバネ掛け(HOOK DEVELOPING  
RAIL RETURN SPRING)

現像(GENZOU)レール戻しバネ掛け(後)(HOOK DEVELOPING  
RAIL RETURN SPRING(AFTER))

現像機(GENZOUKI)トナーなしチェック(CHECK NO TONER  
IN DEVELOPER)

現像機(GENZOUKI)エラーチェック(CHECK ERROR IN  
DEVELOPER)

現像機(GENZOUKI)ロック(LOCK DEVELOPER)

FIG. 11

1100

WORK STANDARD SYSTEM

WORK NAME :

WORK METHOD :

1101 (COMMENT 1)

1102 (OBJECT) ~を

1103 (COMMENT 2)

1104 (VERB) ~する

00 ※

01

1105a

1105b

1105

NOTE, STANDARD / REQUIRED QUALITY :

1106

1107

1108

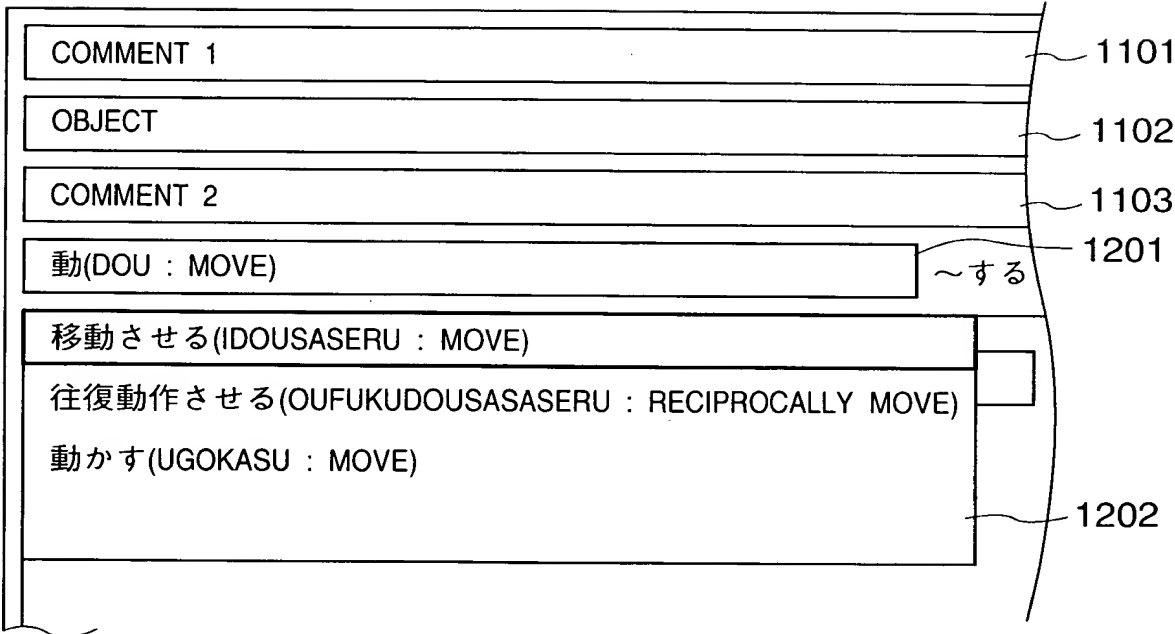
OK CANCEL

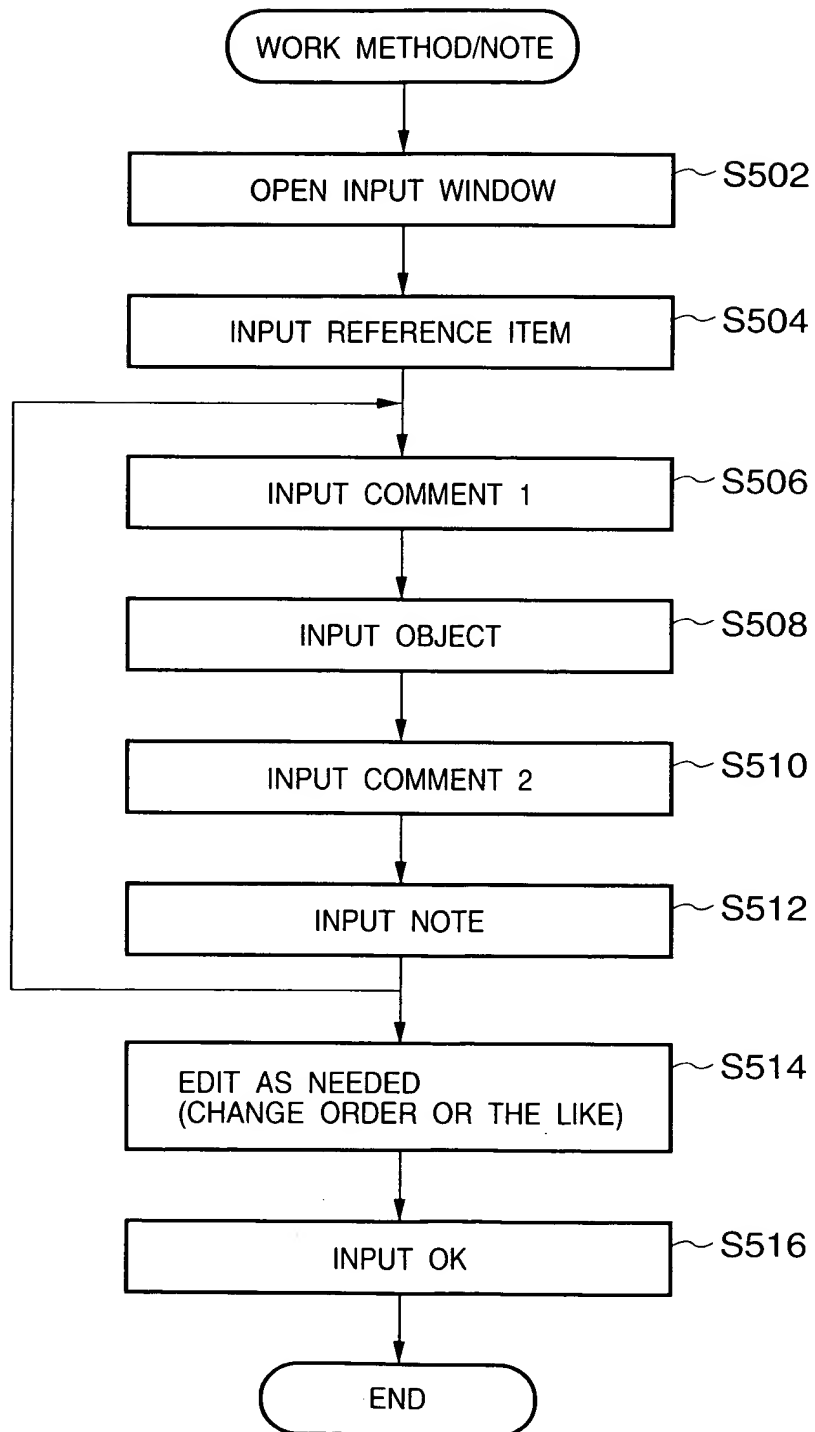
12/97

FIG. 12

WORK STANDARD SYSTEM	
WORK NAME :	
WORK METHOD :	
	1201
	1202
00 ※	1105b
01	

FIG. 13



**FIG. 14**

15/97

**FIG. 15**

00	※	
01	DO zzzz SUCH THAT xxxx AT wwww POSITION BECOMES yyyy	
02	WIND AV CORD	
03	CONFIRM 100V SYSTEM	
04	SET CRG HOLDER	

# FIG. 16

NOTE, STANDARD / REQUIRED QUALITY

NOTE

SEPARATION GRIPPER MOVES SLOWLY WITHOUT GRIPPER SPRING OF ASFu  
 DON'T PULL TAPE TOO STRONG TO MAKE SIDE GUIDE LOOSE  
 DON'T HOOK PAPER GUIDE u ON SHEET HOLDER  
 BEWARE OF IMITATIONS  
 BEWARE OF IMITATIONS(Color Style Write

1601

1602



**FIG. 17**

NOTE, STANDARD / REQUIRED QUALITY	
1	NOTE

1107

FIG. 18

CONFIRM	
00 ※	
01 CONFIRM 100V SYSTEM	
02 WIND AV CORD	CUT(I)
03 SET CRG HOLDER	COPY(C)
04	PASTE(P)
	ADD(A)
	DELETE(D)
	UNDO
NOTE, STANDARD / REQUIRED QUALITY	REVISE(CHANGE)
	REVISE(DELETE)

1802

CONFIRM	～する
00 ※	
01 WIND AV CORD	
02 CONFIRM 100V SYSTEM	
03 SET CRG HOLDER	
04	

NOTE, STANDARD / REQUIRED QUALITY

NOTE, STANDARD / REQUIRED QUALITY

**FIG. 20**

CONFIRM	
00 ※	
01 WIND AV CORD	
02 SET CRG HOLDER	
03	<div> <div>CUT(I)</div> <div>COPY(C)</div> <div>PASTE(P)</div> <div>ADD(A)</div> <div>DELETE(D)</div> <div>UNDO</div> <div>REVISE(CHANGE)</div> <div>REVISE(DELETE)</div> </div>
NOTE, STANDARD / REQUIRED QUALITY	

1802

21/97

FIG. 21





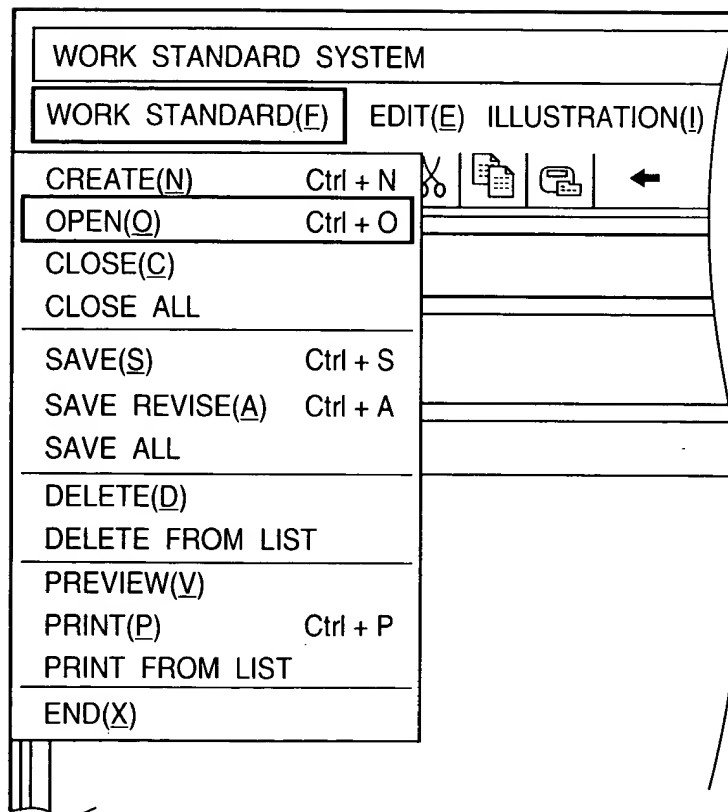
WORK STANDARD SYSTEM	
WORK STANDARD(F)	EDIT(E) ILLUSTRATION(I) SHIPMENT DESTINATION
CREATE(N) Ctrl + N	   
OPEN(O) Ctrl + O	
CLOSE(C)	
CLOSE ALL	
SAVE(S) Ctrl + S	
SAVE REVISE(A) Ctrl + A	
SAVE ALL	PART
DELETE(D)	
DELETE FROM LIST	
PREVIEW(V)	
PRINT(P) Ctrl + P	
PRINT FROM LIST	
END(X)	

FIG. 22



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FIG. 23

WORK STANDARD SYSTEM

◎ LATEST REVISION NUMBER

○ ALL

MANAGEMENT NO.	REVISION NUMBER	WORK NAME	DATE OF REGISTRATION
SO-04-01(4)-E	01	ASFu取付	1997/09/13
SO-01-01(3)-E	01	ベース・トレーu取付	1997/09/01
SO-01-03-E	01	ベース・トレーu取付	1997/09/01
SO-01-04-E	01	ベース・トレーu取付	1997/09/01

線処理

線処理

線処理

レーलगリス塗布





レール取付

SO-06-01-E	01	線処理	1997/09/01
SO-06-02-E	01	線処理	1997/09/01
SO-06-03-E	01	線処理	1997/09/01
SO-07-01(2)-E	01	レーलगリス塗布	1997/09/01
SO-08-01-E	01	レール取付	1997/09/01

OK

CANCEL

FIG. 24

SYSTEM			
EDIT(E)		ILLUSTRATION(I)	SHIPMENT DESTINATION(S)
		VIEW(V)	 
01 CREATE		EDIT(E)	
		PowerPoint	
		✓ Canvas	



302

[illegible]

FIG. 26

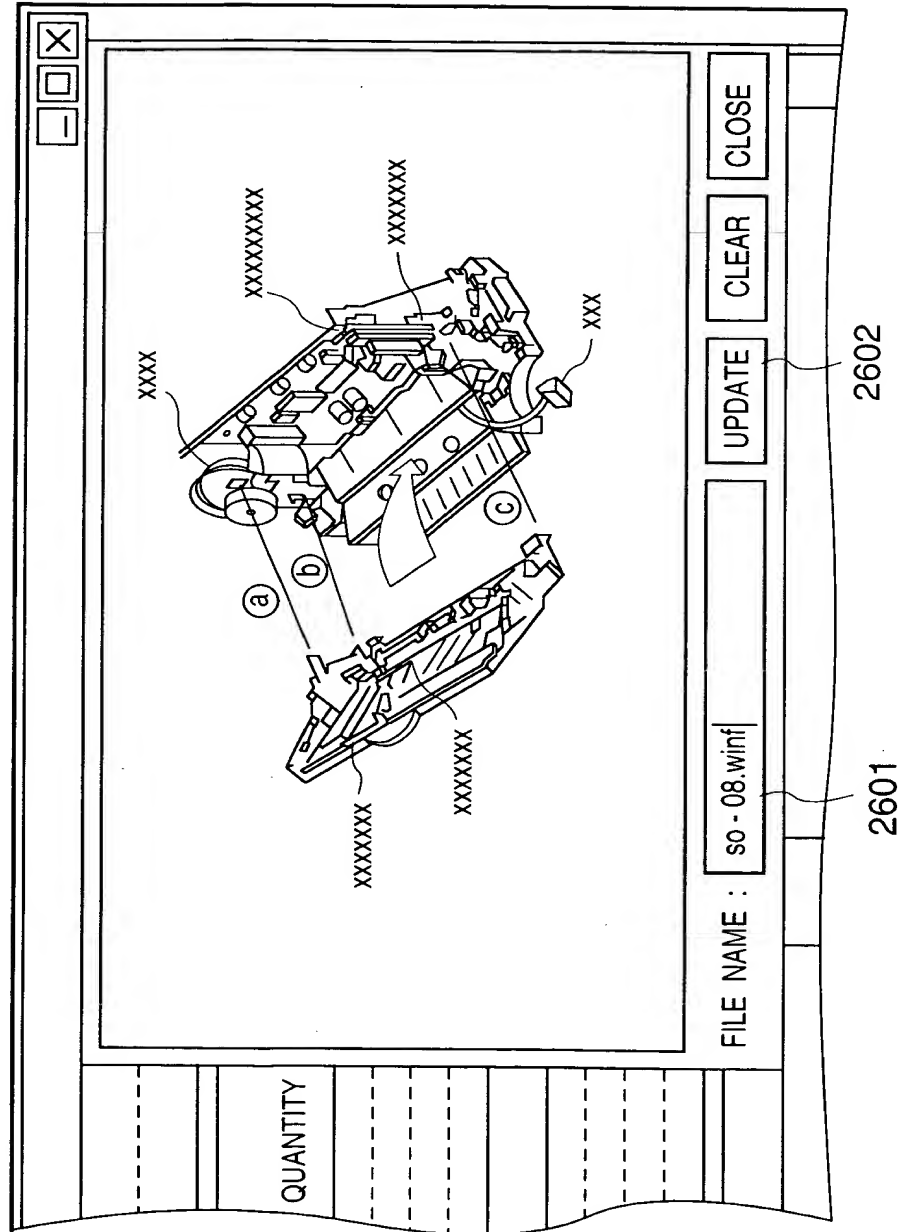


FIG. 27

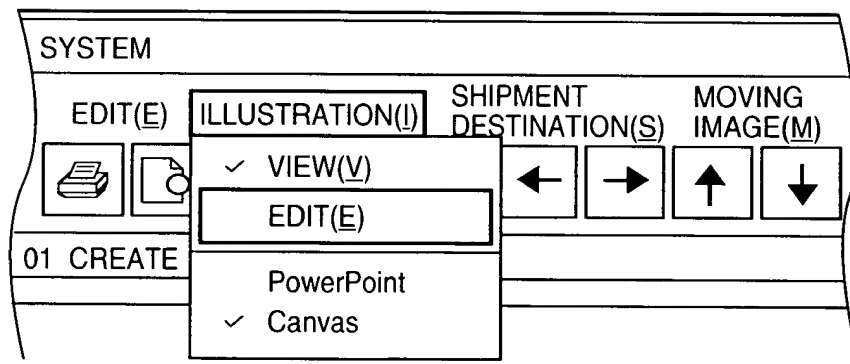


FIG. 28

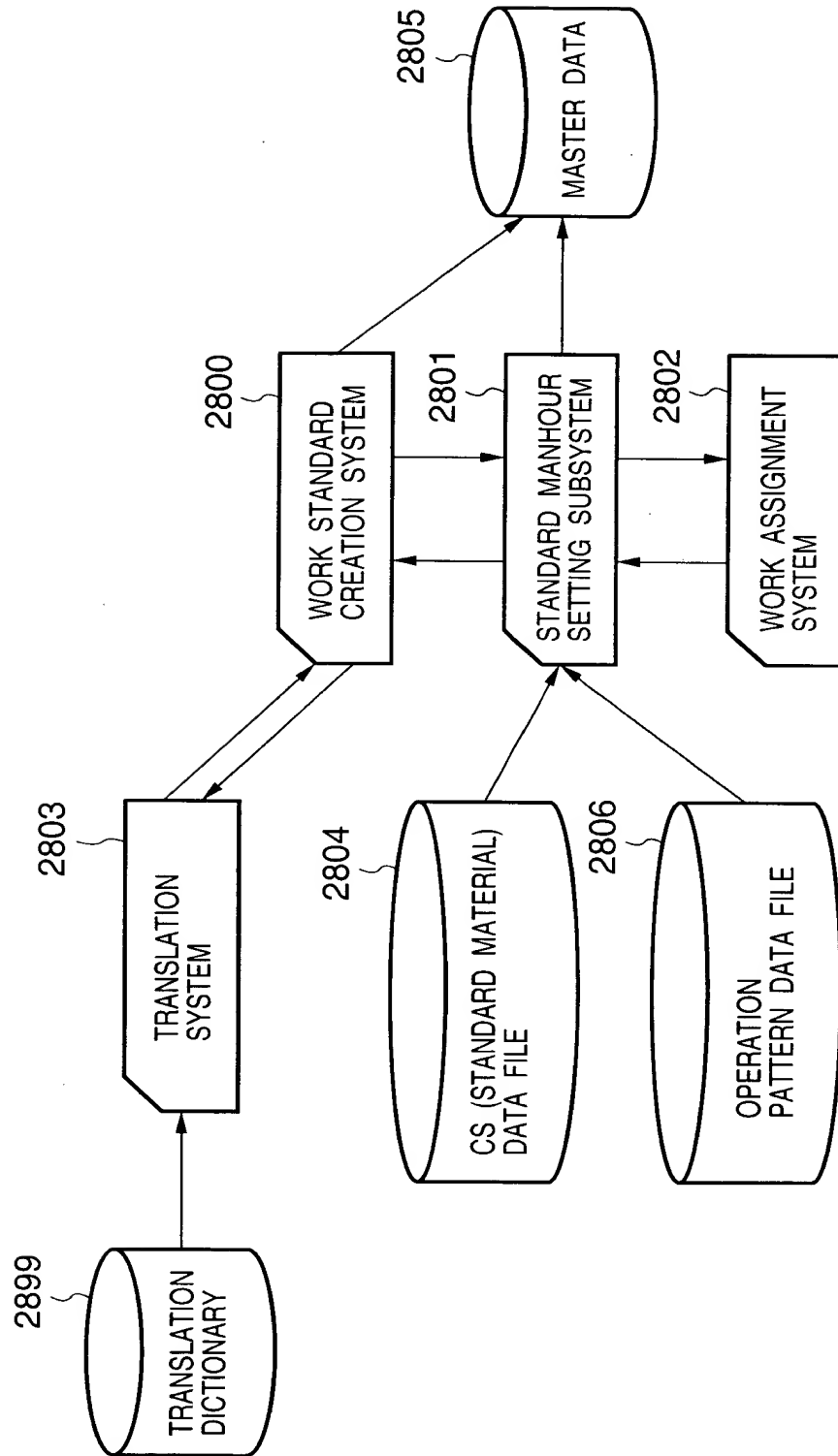


FIG. 29

WORK STANDARD : TRANSLATION SYSTEM (PROTOTYPE) [X]

☒ WORK STANDARD DATA

☐ MASTER DATA

UPLOAD WORK STANDARD

DOWNLOAD WORK STANDARD

TRANSLATE WORK STANDARD

END

FIG. 30

3001 3002 3003 3004

TRANSLATION OF WORK STANDARD

REPRESENTATIVE MODEL NAME : A252

PREPUCES NAME : PLATEN UNIT

☐ TOTAL  
☒ ASSEMBLY  
☐ UNIT  
☒ ASSEMBLY

DISPLAY DATA

☒ ALL  
☐ UNTRANSLATED  
☐ UNCHECKED

DISPLAY LANGUAGE

☐ JAPANESE  
☒ ENGLISH

3000

MANAGEMENT NO.	REVISION NUMBER	WORK NAME	AUTOMATIC TRANSLATION	CHECK
PT - 010 - 010	01	クリーナu取付	X	X
PT - 010 - 020	01	クリーナu取付	X	X
PT - 010 - 030	01	クリーナu取付	X	X
PT - 070 - 030	01	切換アームAssy組立	X	X
PT - 080 - 010	01	伝達ローラu取付	X	X
PT - 090 - 010	01	伝達ローラu取付	X	X
PT - 100 - 010	01	紙押え取付	X	X

3006

SELECT ALL CANCEL SELECT VIEW TRANSLATE TRANSLATE ALL CLOSE

3007 3008 3005

# FIG. 31

TRANSLATION OF WORK STANDARD (PROTOTYPE)									
WORK STANDARD(E) ILLUSTRATION(I) VOICE(S) WINDOW(W)									
WORK STANDARD PN-030-020 01 New created by (PX2056) A252 PUMP UNIT									
Model	QG5-1319								
Part No.	Part Name	Qty	Part No.	Part Name	Qty				
Total					Qty	PN			
No.	Procedure				No.	Precaution / Conditions			
01	The blade lever spring hooks to ① of the blade lever.				02 - 01	No Table Data 1			
02	Side the blade lever in the direction of arrow ② and check there is no catch and nor the return by the spring force.				03 - 01	No Table Data 1			
03	Check press-fitting the blade lever shaft leading edge to the braid folder leading edge.								
Details is of Revision		Data	By	OK	Procedure				
01 New Created by (PX2056)					No Table Data 1				
					Page No.				
					PN-030-020				

3101

FIG. 32

3200

WORK PROCEDURE <span style="float: right;">✕</span>	
VOICE(W)	
JAPANESE	
WORK PROCEDURE	
ブレードレバーハネをブレードレバーの ① 部に引っ掛ける	<div style="border: 1px solid black; padding: 5px;"> <p>01 ブレードレバーハネをブレードレバーの ① 部に引っ掛ける</p> <p>02 ブレードレバーを矢印 ② 方向にスライドさせ引っ掛かり無くハネ力で戻ることを確認する</p> <p>03 ブレードレバー軸先端がブレードホルダー先端まで圧入されていることを確認する</p> </div>
ENGLISH	
Procedure	
The blade lever spring hooks to ① of the blade lever.	<div style="border: 1px solid black; padding: 5px;"> <p>01 The blade lever spring hooks to ① of the blade lever.</p> <p>02 Side the blade lever in the direction of arrow ② and there is no catch, and n....</p> <p>03 Check press-fitting the blade lever shaft leading edge to the braid folder leading ed....</p> </div>
<div style="display: flex; justify-content: space-between; align-items: center;"> <span>◀</span> <span>▶</span> </div>	
<div style="display: flex; justify-content: space-around;"> <div style="border: 1px solid black; padding: 5px 10px;">TRANSLATE</div> <div style="border: 1px solid black; padding: 5px 10px;">OK</div> <div style="border: 1px solid black; padding: 5px 10px;">CANCEL</div> </div>	

3201

3202

3203

3204

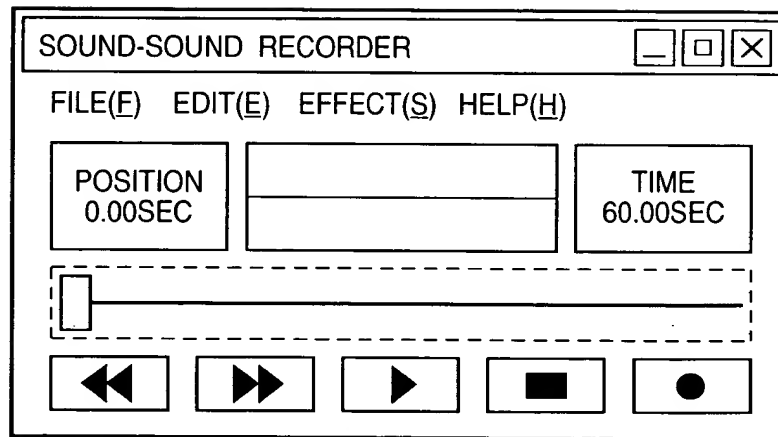


U.S. GOVERNMENT PRINTING OFFICE: 1975 O - 345-131

FIG. 33

TRANSLATION OF WORK STANDARD (PROTOTYPE)		<div><div></div><div></div><div></div></div>	
WORK STANDARD(E) ILLUSTRATION(I)		VOICE(S) DOW(W)	
WORK STANDARD PN-030-020 01 New		PLAY(P)	
Model QG5-1317		NEW(N)	
		DRIVE(D)	
		X2056) A252 PLATEN UNIT	
		<div><div></div><div></div><div></div></div>	

FIG. 34



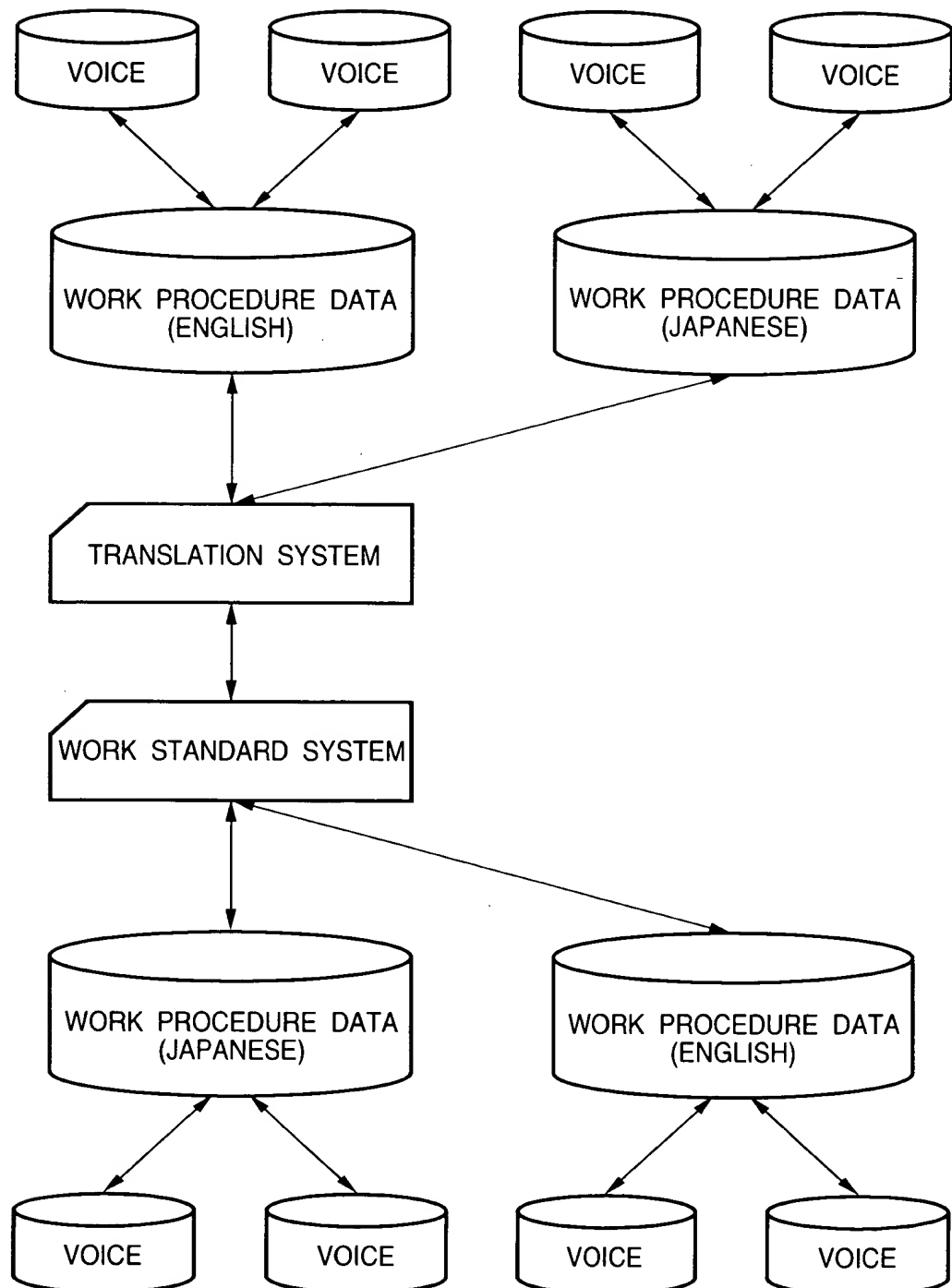
**FIG. 35**

FIG. 36

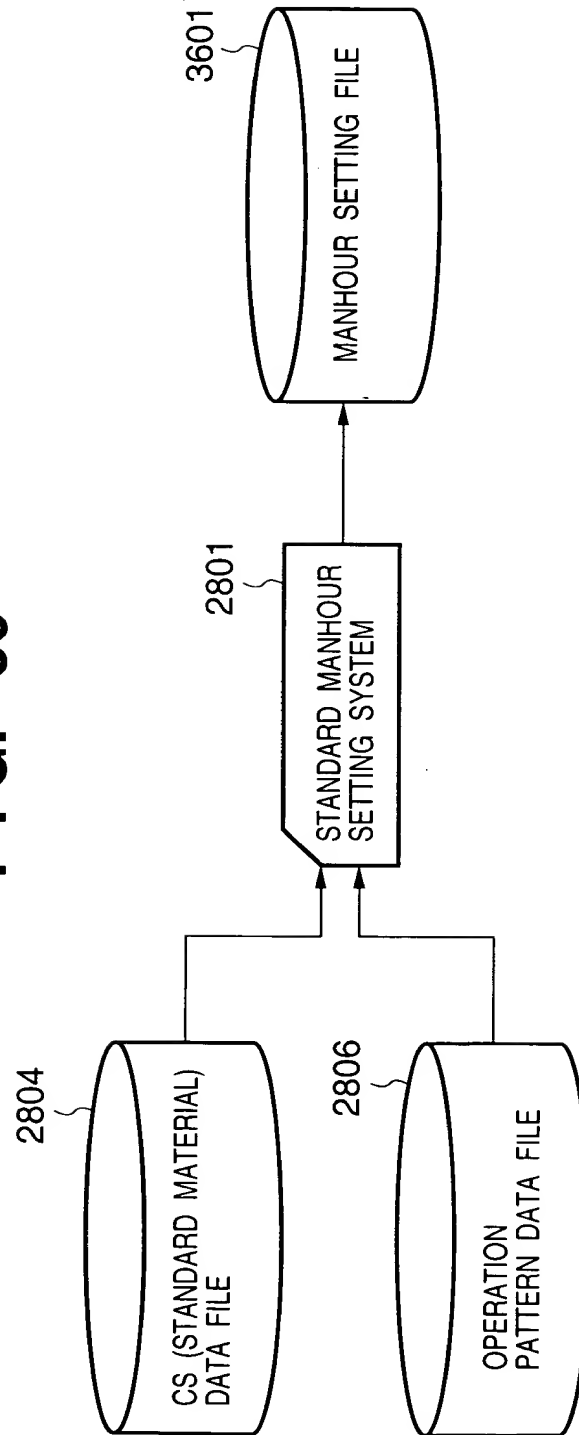


FIG. 37

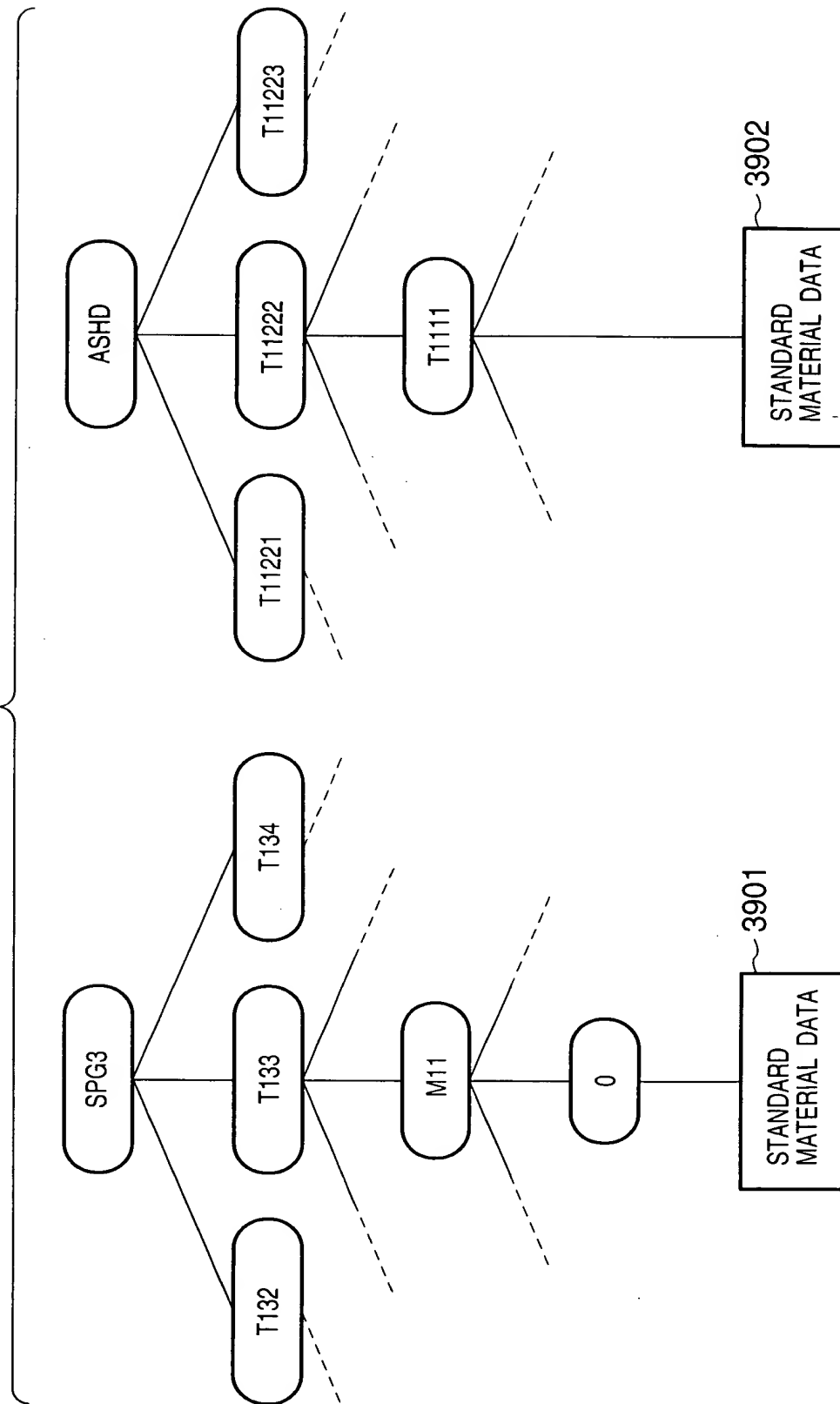
No.	ELEMENT WORK NAME	FREQUENCY	MANHOUR	CS	SET CONDITION

FIG. 38

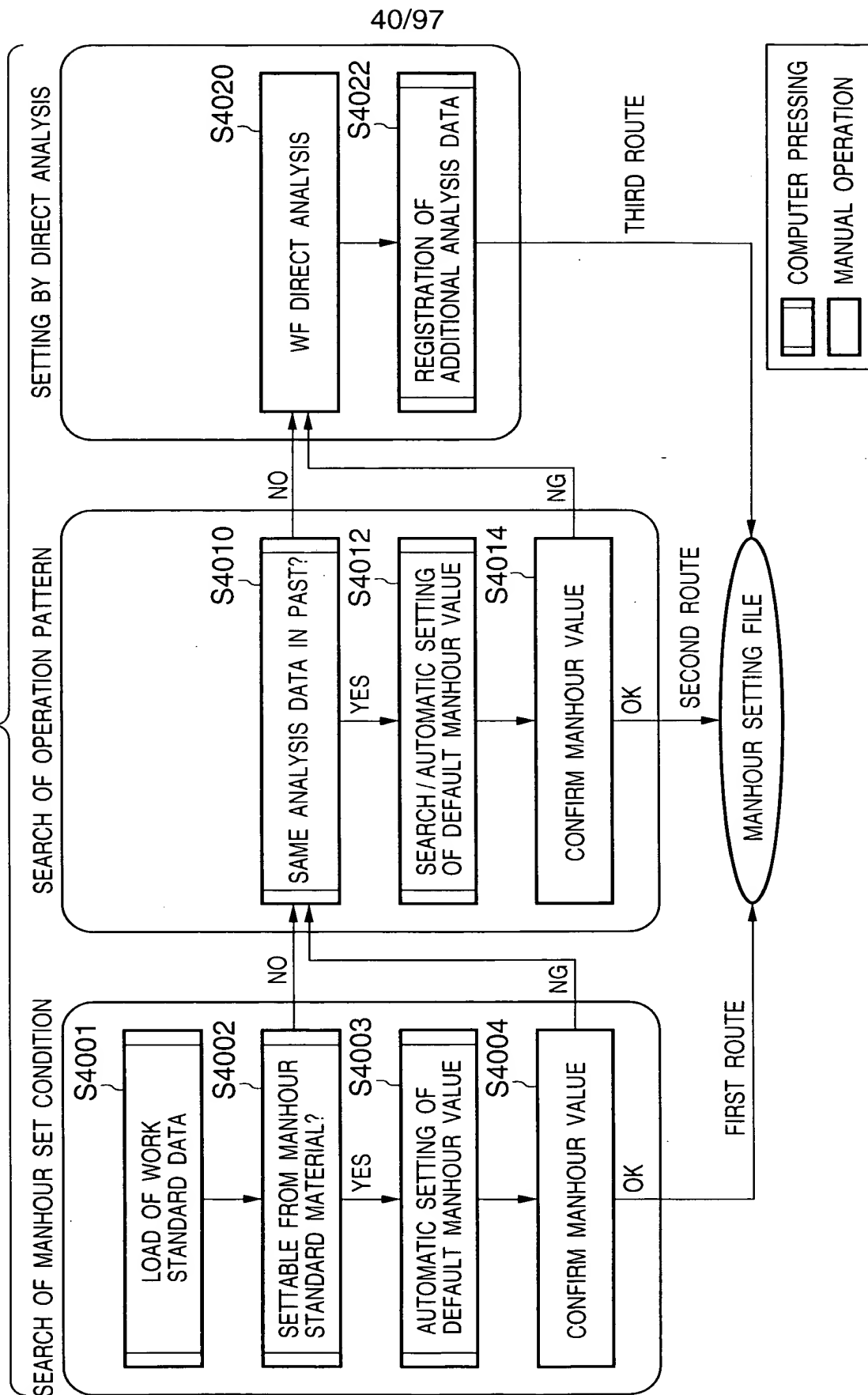
STANDARD MATERIAL DATA

COMMENT 1	OBJECT	COMMENT 2	VERB	SET CONDITION DATA

FIG. 39



# FIG. 40







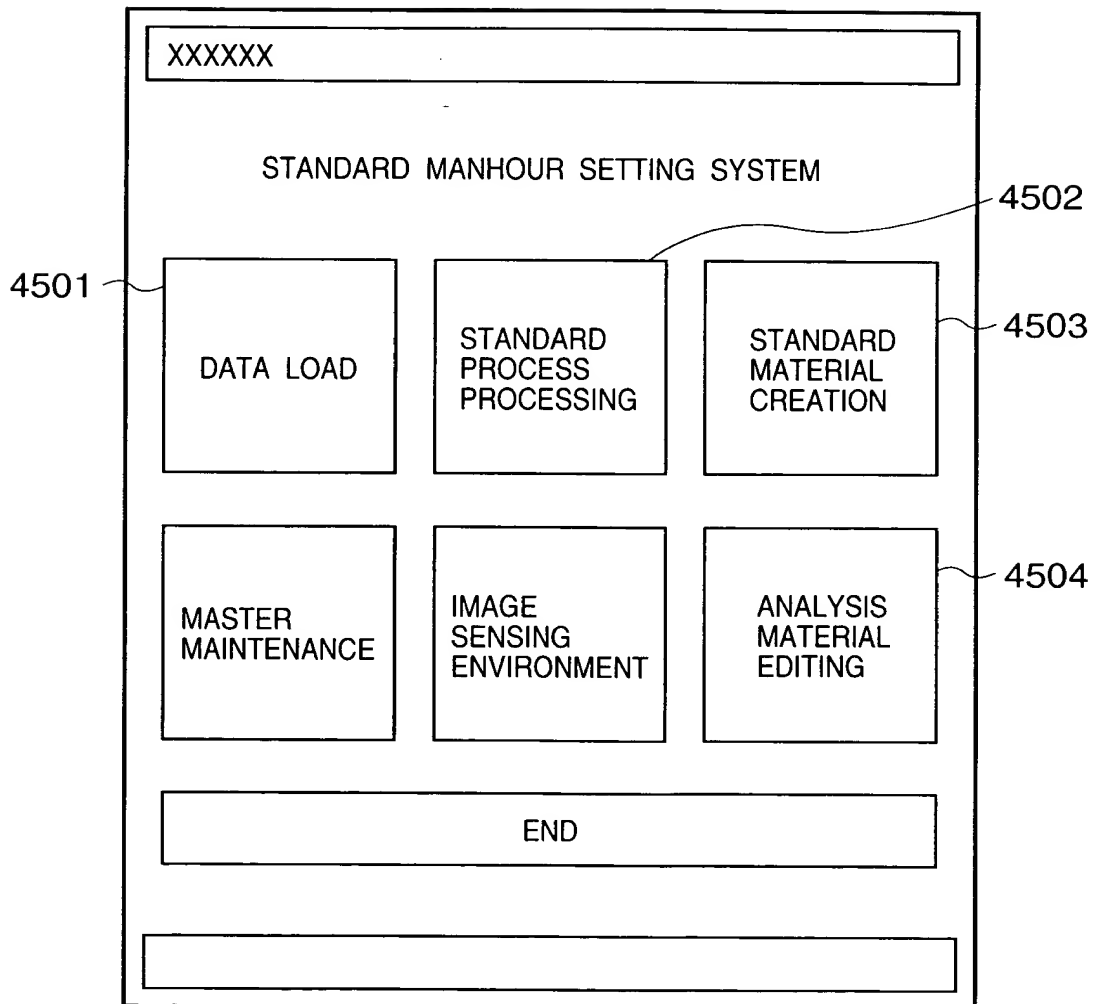


[illegible]2806 

**FIG. 44**

[illegible]

**FIG. 45**



4609 4610

4601

4612

4602

4603

4604

4605

4611

XXXXXXXX

PRODUCT NUMBER: 1

PRODUCT SYMBOL: XX

NAME: XXXX

PREVIOUS LOAD DATE: XXX

PRODUCT NUMBER

0 - CLOCK

XXXXXX

xyz - test

test - 01

tesr - AMI

SELECT

CANCEL

4704

FIG. 48

LOAD OF DATA

COMPONENT DESIGNATION

☐ ALL

☒ DESIGNATE COMPONENT

4802

CH

AUTOMATIC MANHOUR SETTING

☒ STANDARD MATERIAL(CS)

☒ ANALYSIS MATERIAL

EXECUTE

CANCEL

4806



FIG. 49

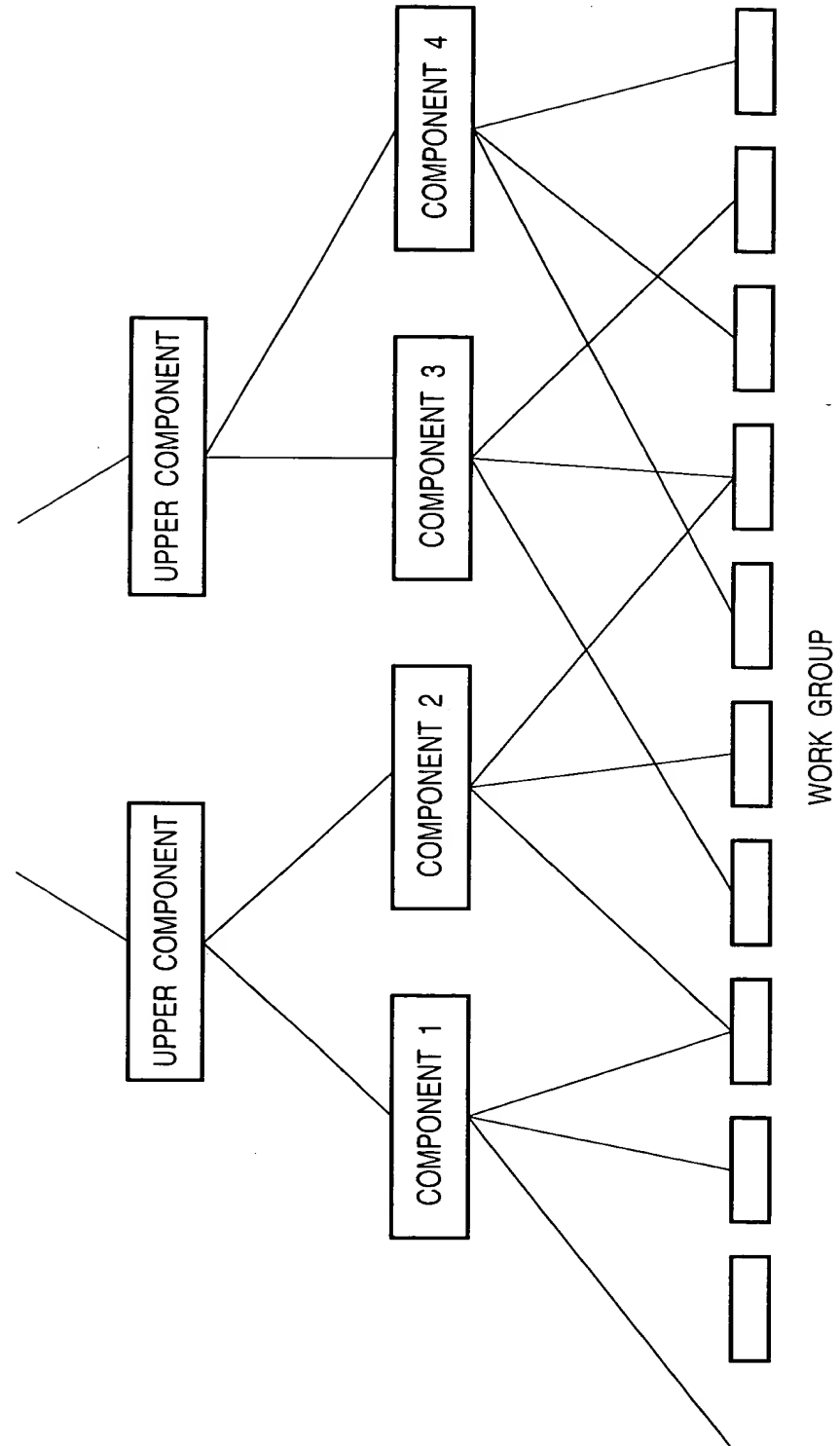
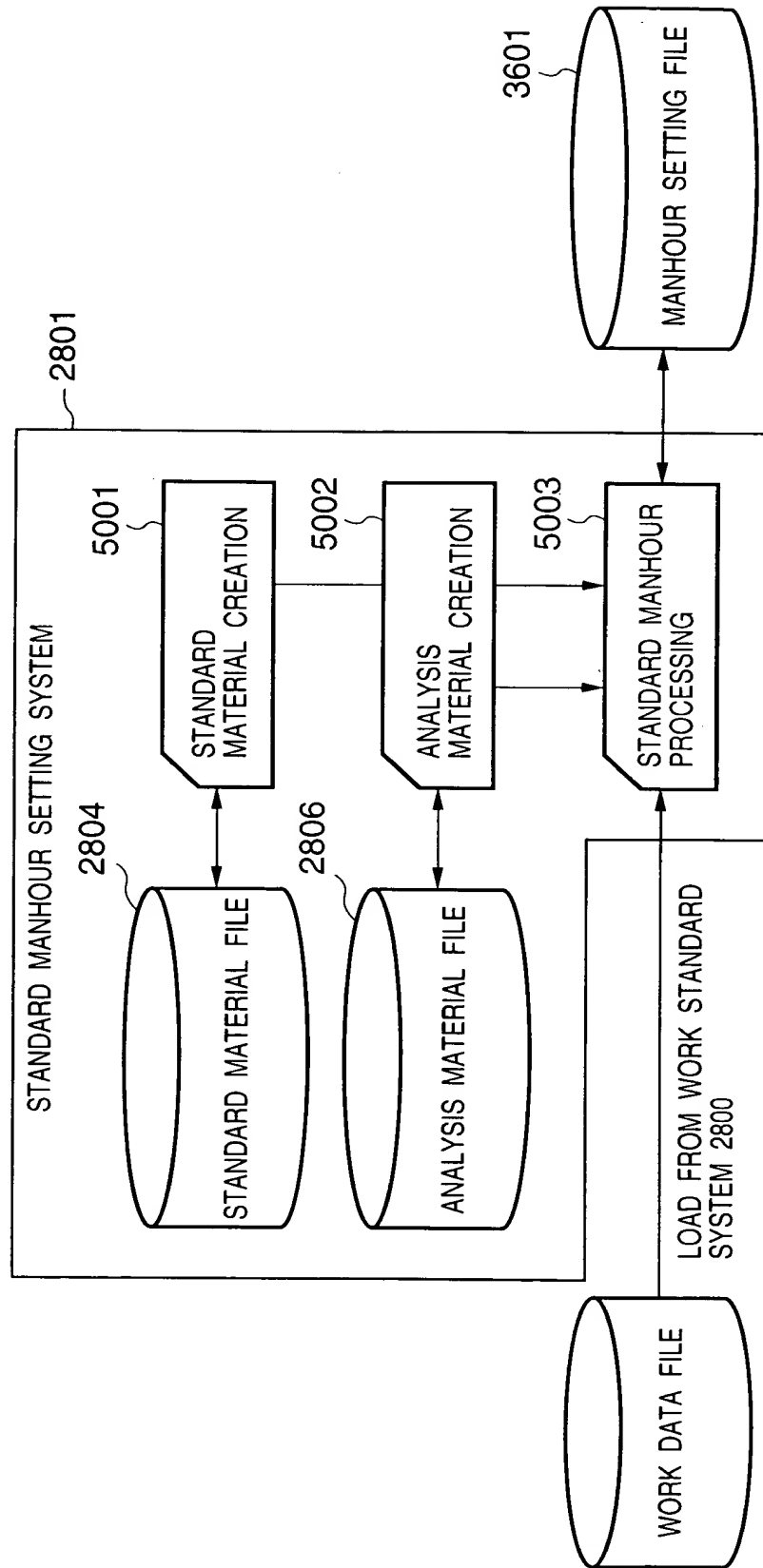
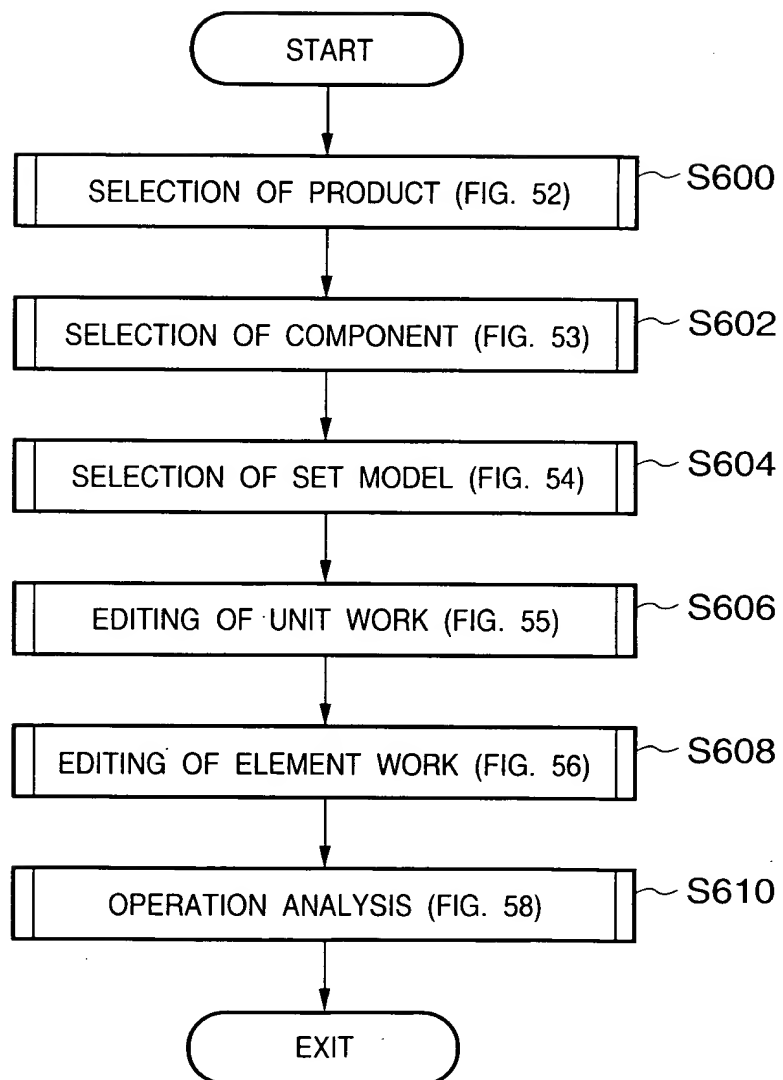


FIG. 50



**FIG. 51**



[illegible][illegible]

*(The page contains faint, illegible markings or bleed-through from the reverse side.)*

5301

[illegible][illegible]

DATE	DESCRIPTION	AMOUNT	BALANCE
1890	Jan 1		100.00
	Feb 1	50.00	150.00
	Mar 1	25.00	175.00
	Apr 1	75.00	250.00
	May 1	100.00	350.00
	Jun 1	150.00	500.00
	Jul 1	200.00	700.00
	Aug 1	250.00	950.00
	Sep 1	300.00	1250.00
	Oct 1	350.00	1600.00
	Nov 1	400.00	2000.00
	Dec 1	450.00	2450.00
1891	Jan 1	500.00	2950.00
	Feb 1	550.00	3500.00
	Mar 1	600.00	4100.00
	Apr 1	650.00	4750.00
	May 1	700.00	5450.00
	Jun 1	750.00	6200.00
	Jul 1	800.00	7000.00
	Aug 1	850.00	7850.00
	Sep 1	900.00	8750.00
	Oct 1	950.00	9700.00
	Nov 1	1000.00	10700.00
	Dec 1	1050.00	11750.00
1892	Jan 1	1100.00	12850.00
	Feb 1	1150.00	14000.00
	Mar 1	1200.00	15200.00
	Apr 1	1250.00	16450.00
	May 1	1300.00	17750.00
	Jun 1	1350.00	19100.00
	Jul 1	1400.00	20500.00
	Aug 1	1450.00	21950.00
	Sep 1	1500.00	23450.00
	Oct 1	1550.00	25000.00
	Nov 1	1600.00	26600.00
	Dec 1	1650.00	28250.00
1893	Jan 1	1700.00	29950.00
	Feb 1	1750.00	31700.00
	Mar 1	1800.00	33500.00
	Apr 1	1850.00	35350.00
	May 1	1900.00	37250.00
	Jun 1	1950.00	39200.00
	Jul 1	2000.00	41200.00
	Aug 1	2050.00	43250.00
	Sep 1	2100.00	45350.00
	Oct 1	2150.00	47500.00
	Nov 1	2200.00	49700.00
	Dec 1	2250.00	51950.00
1894	Jan 1	2300.00	54250.00
	Feb 1	2350.00	56600.00
	Mar 1	2400.00	59000.00
	Apr 1	2450.00	61450.00
	May 1	2500.00	63950.00
	Jun 1	2550.00	66500.00
	Jul 1	2600.00	69100.00
	Aug 1	2650.00	71750.00
	Sep 1	2700.00	74450.00
	Oct 1	2750.00	77200.00
	Nov 1	2800.00	80000.00
	Dec 1	2850.00	82850.00
1895	Jan 1	2900.00	85750.00
	Feb 1	2950.00	88700.00
	Mar 1	3000.00	91700.00
	Apr 1	3050.00	94750.00
	May 1	3100.00	97850.00
	Jun 1	3150.00	101000.00
	Jul 1	3200.00	104200.00
	Aug 1	3250.00	107450.00
	Sep 1	3300.00	110750.00
	Oct 1	3350.00	114100.00
	Nov 1	3400.00	117500.00
	Dec 1	3450.00	120950.00
1896	Jan 1	3500.00	124450.00
	Feb 1	3550.00	128000.00
	Mar 1	3600.00	131600.00
	Apr 1	3650.00	135250.00
	May 1	3700.00	138950.00
	Jun 1	3750.00	142700.00
	Jul 1	3800.00	146500.00
	Aug 1	3850.00	150350.00
	Sep 1	3900.00	154250.00
	Oct 1	3950.00	158200.00
	Nov 1	4000.00	162200.00
	Dec 1	4050.00	166250.00
1897	Jan 1</		

DATE	DESCRIPTION	AMOUNT	BALANCE
1890	Jan 1		100.00
	Feb 1	50.00	150.00
	Mar 1	25.00	175.00
	Apr 1	75.00	250.00
	May 1	100.00	350.00
	Jun 1	150.00	500.00
	Jul 1	200.00	700.00
	Aug 1	250.00	950.00
	Sep 1	300.00	1250.00
	Oct 1	350.00	1600.00
	Nov 1	400.00	2000.00
	Dec 1	450.00	2450.00
1891	Jan 1	500.00	2950.00
	Feb 1	550.00	3500.00
	Mar 1	600.00	4100.00
	Apr 1	650.00	4750.00
	May 1	700.00	5450.00
	Jun 1	750.00	6200.00
	Jul 1	800.00	7000.00
	Aug 1	850.00	7850.00
	Sep 1	900.00	8750.00
	Oct 1	950.00	9700.00
	Nov 1	1000.00	10700.00
	Dec 1	1050.00	11750.00
1892	Jan 1	1100.00	12850.00
	Feb 1	1150.00	14000.00
	Mar 1	1200.00	15200.00
	Apr 1	1250.00	16450.00
	May 1	1300.00	17750.00
	Jun 1	1350.00	19100.00
	Jul 1	1400.00	20500.00
	Aug 1	1450.00	21950.00
	Sep 1	1500.00	23450.00
	Oct 1	1550.00	25000.00
	Nov 1	1600.00	26600.00
	Dec 1	1650.00	28250.00
1893	Jan 1	1700.00	29950.00
	Feb 1	1750.00	31700.00
	Mar 1	1800.00	33500.00
	Apr 1	1850.00	35350.00
	May 1	1900.00	37250.00
	Jun 1	1950.00	39200.00
	Jul 1	2000.00	41200.00
	Aug 1	2050.00	43250.00
	Sep 1	2100.00	45350.00
	Oct 1	2150.00	47500.00
	Nov 1	2200.00	49700.00
	Dec 1	2250.00	51950.00
1894	Jan 1	2300.00	54250.00
	Feb 1	2350.00	56600.00
	Mar 1	2400.00	59000.00
	Apr 1	2450.00	61450.00
	May 1	2500.00	63950.00
	Jun 1	2550.00	66500.00
	Jul 1	2600.00	69100.00
	Aug 1	2650.00	71750.00
	Sep 1	2700.00	74450.00
	Oct 1	2750.00	77200.00
	Nov 1	2800.00	80000.00
	Dec 1	2850.00	82850.00
1895	Jan 1	2900.00	85750.00
	Feb 1	2950.00	88700.00
	Mar 1	3000.00	91700.00
	Apr 1	3050.00	94750.00
	May 1	3100.00	97850.00
	Jun 1	3150.00	101000.00
	Jul 1	3200.00	104200.00
	Aug 1	3250.00	107450.00
	Sep 1	3300.00	110750.00
	Oct 1	3350.00	114100.00
	Nov 1	3400.00	117500.00
	Dec 1	3450.00	120950.00
1896	Jan 1	3500.00	124450.00
	Feb 1	3550.00	128000.00
	Mar 1	3600.00	131600.00
	Apr 1	3650.00	135250.00
	May 1	3700.00	138950.00
	Jun 1	3750.00	142700.00
	Jul 1	3800.00	146500.00
	Aug 1	3850.00	150350.00
	Sep 1	3900.00	154250.00
	Oct 1	3950.00	158200.00
	Nov 1	4000.00	162200.00
	Dec 1	4050.00	166250.00
1897	Jan 1</		

**FIG. 56**

XXXXXX									
<div style="display: flex; justify-content: space-around; align-items: center;"> <div style="display: flex; gap: 5px;"> <div style="border: 1px solid black; padding: 2px 5px;">🏠</div> <div style="border: 1px solid black; padding: 2px 5px;">📄</div> <div style="border: 1px solid black; padding: 2px 5px;">✖</div> <div style="border: 1px solid black; padding: 2px 5px;">📁</div> <div style="border: 1px solid black; padding: 2px 5px;">🔍</div> </div> <div style="border: 1px solid black; padding: 2px 5px;">NEXT UNIT WORK</div> </div>									
<div style="display: flex; justify-content: space-between;"> <div>FORMAL MANAGEMENT NO. PU-03-01</div> <div>UNIT WORK NAME: MOTOR ATTACHMENT</div> <div>TOTAL MANHOUR: 0</div> </div>									
NO.	ELEMENT WORK NAME	REVISION	MANHOUR	USE	CS	SET CONDITION			
▶ 1	LFモータのケーブルと反対側の軸にダブルギア	1	0	0					
*									

COMMENT 1 :	LFモータのケーブルと反対側の軸に
OBJECT :	ダブルギアを
COMMENT 2 :	ギア径の小さい方から
VERB :	<div style="display: flex; justify-content: space-between;"> <div>取付ける</div> <div>設定</div> </div>



✕  
☐  
☐

FILE(F) EDIT(E) VIEW(V)

ALL 

TYPE	COMMENT 1	OBJECT	COMMENT 2	VERB	ANALYSIS SYMBOL	MANHOUR	USE	FREQUENCY	COUNT	SET DATE
▶	IP-キャップ:	本体を	矢印1の様に	入れる	-50/Gr1/N/>6/-3	15	0	1	0	97/09/09 9:52
	IP-キャップ:	本体を	矢印1の様に	入れる	-50/E/02/N/-6	11	0	1	0	97/09/09 9:53
	IP-キャップ:	本体を	矢印1の様に	入れる	-50/Gr1/N/>6/-3	15	0	1	0	97/09/09 9:55
		要素作業01		動詞	-50/Gr1/N/>6/-3	15	0	1	0	97/09/10 16:34
	IP-キャップ:	本体を	矢印1の様に	入れる	-50/Gr1/N/>6/-3	15	0	1	0	97/09/10 19:09
	モーター組立:	キャリッジ・ロック		塗布する	Time100/Rate100	100	100	1	1	97/09/10 19:16
		フリンダジャー		入れ、セツとする	M211/1/10	50	1	1	1	97/09/11 17:00
		フリンダジャー		裏面にする	T1221/M2311/0/0	12	0	1	0	97/09/11 17:34
		1		1	T2221/M1211/0/1	24	0	1	0	97/09/11 17:20
		2		2	T1221/M2311/0/0	12	0	1	0	97/09/11 17:24
		フリンダジャー	PRが「ト」取付る	セツとする		15	0	1	0	97/09/12 11:24
		dgdafdfas		fdaafdaafdaaf	*	16	0	1	0	97/09/12 12:10
		dscdfsfdsaf		fdaafdaafdaaf	T2121/M1111/0/1	13	0	1	0	97/09/12 12:10
		dgdafdfas		fdaafdaafdaaf	*	16	0	1	0	97/09/12 13:39
		フリンダジャー	PRが「ト」取付る	セツとする		15	0	1	0	97/09/12 14:00
		フリンダジャー	PRが「ト」取付る	セツとする		15	0	1	0	97/09/12 14:00
		フリンタユニット		セツとする	Time100/Rate100	100	100	1	0	97/09/12 14:04

5801	5802	5803	5804	5805
------	------	------	------	------

OPERATION ANALYSIS									
<div> <div> </div> </div>		TOTAL SIMO VALUE : 0		TOTAL MANHOURLY VALUE : 15		SIMO		NEXT ELEMENT WORK	
1 SET MAIN BODY TO PREDETERMINED POSITION									
NO.	CONTENTS OF OPERATION		WF/OS	SET CONDITION	MANHOURLY	USE	REMARKS		
▲ 1	XXXXXX		PU	-60/Gr1/N/>6/-3	15	0			
*									

FIG. 59

5901

<input type="radio"/> 1. PU	<input type="radio"/> 6. DSY	<input type="radio"/> 11. PU	<input type="radio"/> 16. DSY
<input type="radio"/> 2. GET	<input type="radio"/> 7. R	<input type="radio"/> 12. GET	<input type="radio"/> 17. R
<input type="radio"/> 3. M	<input type="radio"/> 8. UMAC	<input type="radio"/> 13. M	
<input type="radio"/> 4. MA	<input type="radio"/> 9. MP	<input type="radio"/> 14. MA	
<input type="radio"/> 5. ASY	<input type="radio"/> 10. BODY	<input type="radio"/> 15. ASY	

☐ SIMO

SELECT

CANCEL

5902

# FIG. 60

XXXXXXX

PU

PICK UP

MANUAL

1 :	MOVING DISTANCE	1	-10cm	2	+10cm	3	>50cm	4	5	6
2 :	GRIP TYPE		Qr-3		Qr-2					
3 :	PRE-POSITIONING		NO		YES					
4 :	MAIN SIZE		-10mm		-6mm					
5 :	WEIGHT		<3Kg		>3Kg					
6 :										

SET

CANCEL

SET VALUE

FORMULA

6001
6002
6003

FORMULA

TURN

CHANGE DIRECTION OF BODY

MANUAL

FORMULA :

10 \* m

VARIABLE	VARIABLE NAME	VALUE	UNIT
m :	THE NUMBER OF TIMES OF OPERATION OF CHANGING DIRECTION		COUNT
n :			
p :			
q :			
r :			
s :			

SET

CANCEL

SET VALUE

6105

6102

FIG. 62

The figure shows a graphical user interface window titled "INQUIRY OF LOG". The window contains the following elements:

- VARIATION AMOUNT :** A text label followed by a text input field containing the value "10".
- USE :** A text label followed by a text input field containing the value "0".
- REASON CODE :** A text label followed by a small text input field containing the value "1".
- CHANGE REASON :** A text label followed by a dropdown menu. The dropdown menu is currently displaying the text "SET" and has a downward-pointing arrow icon on its right side.
- Buttons:** At the bottom of the window, there are two buttons: "OK" on the left and "Clear" on the right.

Reference numerals are used to identify specific components:

- 6201 points to the title bar area.
- 6202 points to the "VARIATION AMOUNT" input field.
- 6203 points to the "USE" input field.
- 6204 points to the "CHANGE REASON" dropdown menu.
- 6205 points to the "OK" button.
- 6206 points to the "Clear" button.

U.S. GOVERNMENT PRINTING OFFICE: 1985 O - 345-000

FIG. 63

6301 6302

CORRECTION OF CHANGE LOG

DATE 1997 09 22 O = O FROM  
O BEFORE O ~

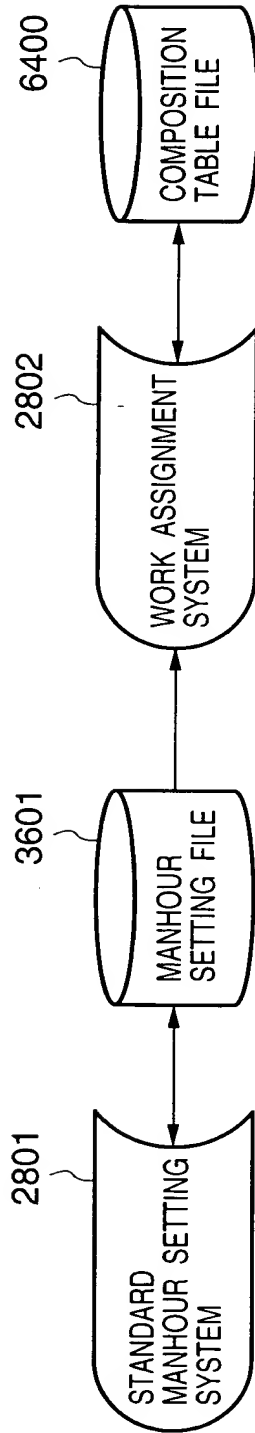
SEARCH

NO.	UNIT WORK NAME	CODE	CHANGE REASON	NEW MANHOUR	(NEW) MANUAL	(NEW) USE	PREVIOUS (PREVIOUS) MANHOUR	(PREVIOUS) USE	CHANGE DATE
▶ CH-01-01	ELECTRICAL CHECK	1	SET	10	10	0	0	0	1997/09/22 14.30.00

REASON CODE 1 CHANGE REASON SET

OK C/R END

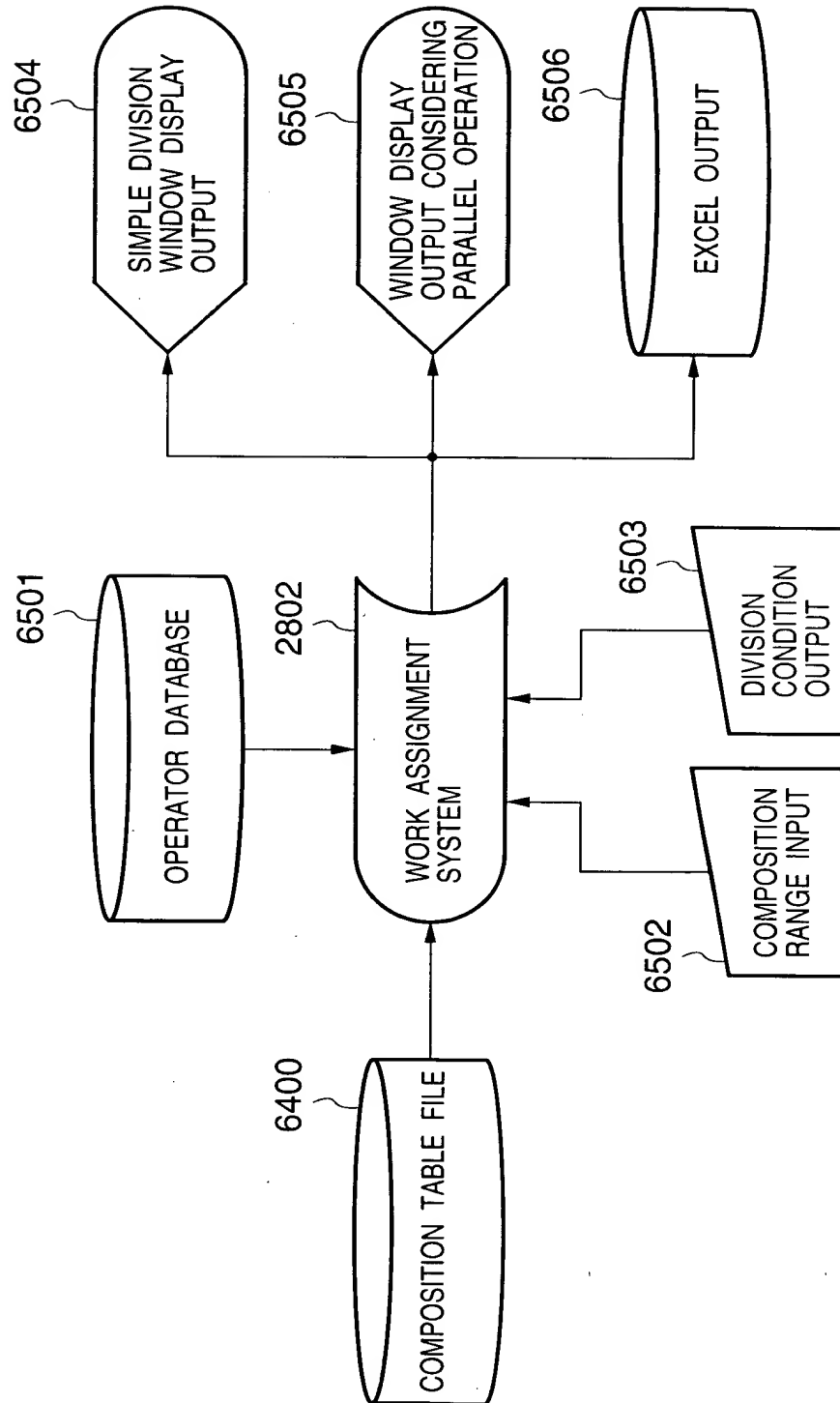
FIG. 64



- DATA LOAD
- DETERMINATION OF COMPOSITION RANGE
- AUTOMATIC COMPOSITION
- CORRECTION OF COMPOSITION
- REGISTRATION OF COMPOSITION RESULT
- OUTPUT OF COMPOSITION

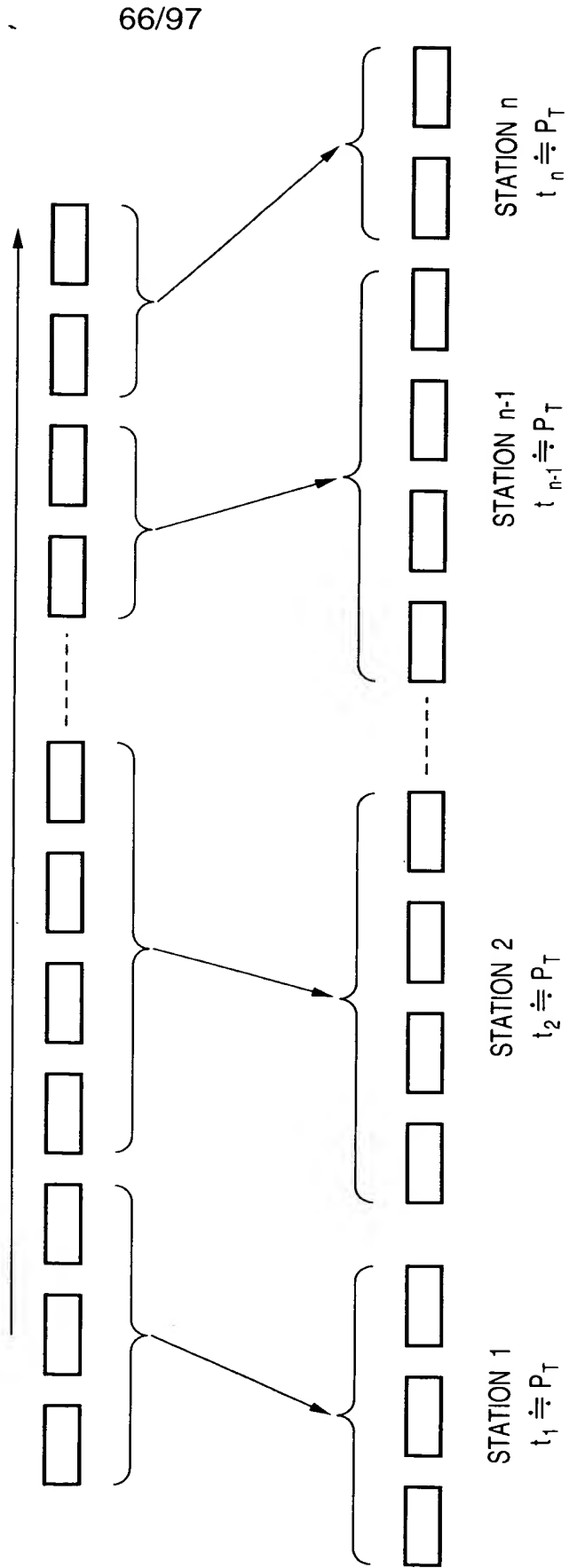


FIG. 65



# FIG. 66

WORK ORDER



# FIG. 67

		▶	▲
FILE(F) EDIT(E) INPUT(I) TOOL(O)			
<div>MODEL</div> <div>GP55</div> <div>UNIT</div> <div></div>			
STANDARD NO.	WORK NAME	MANHOUR	
0001	STICK HANDY CUT TAPE	134	
0002	SET LABELS ON MAIN BODY	550	
0003	WEIMAN REMOVAL	270	
0004	ASSEMBLE OUTER CASE	365	
0005	FIT TOP PAD	268	
0006	STICK LARGE-SIDE ORDER LABEL	117	

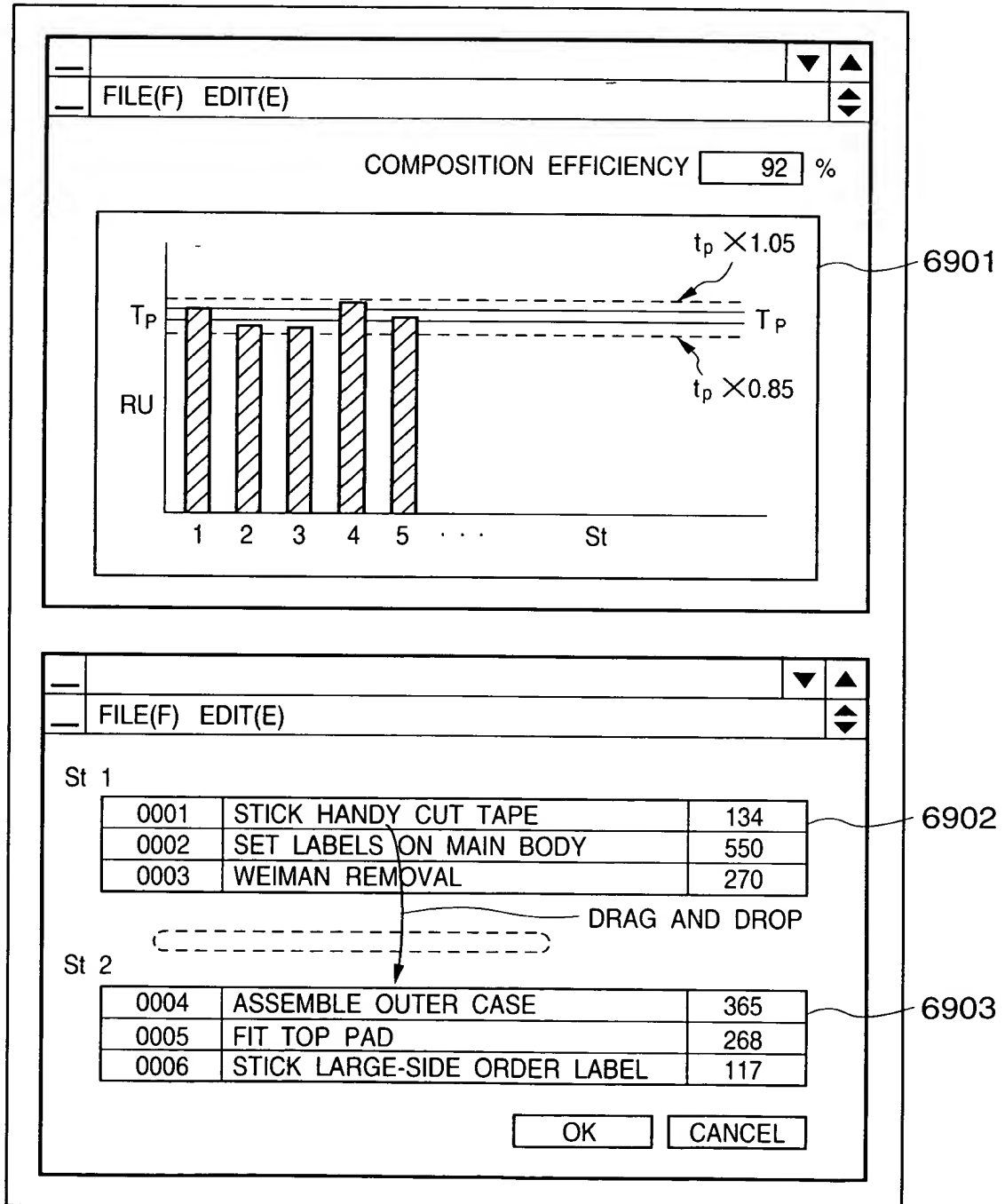
{ SIMPLE DIVISION  
PARALLEL DIVISION

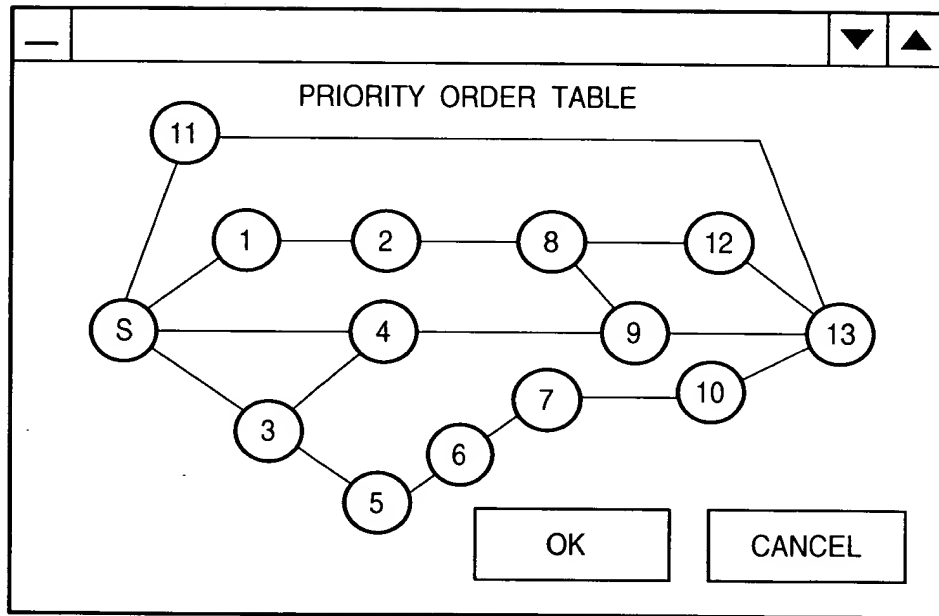
# FIG. 68

## SIMPLE DIVISION

		▼	▲																		
	FILE(F) EDIT(E)	◆																			
<p>St 1</p> <table border="1"> <tr> <td>0001</td> <td>STICK HANDY CUT TAPE</td> <td>134</td> </tr> <tr> <td>0002</td> <td>SET LABELS ON MAIN BODY</td> <td>550</td> </tr> <tr> <td>0003</td> <td>WEIMAN REMOVAL</td> <td>270</td> </tr> </table> <p>St 2</p> <table border="1"> <tr> <td>0004</td> <td>ASSEMBLE OUTER CASE</td> <td>365</td> </tr> <tr> <td>0005</td> <td>FIT TOP PAD</td> <td>268</td> </tr> <tr> <td>0006</td> <td>STICK LARGE-SIDE ORDER LABEL</td> <td>117</td> </tr> </table> <p style="text-align: center;">⋮</p>				0001	STICK HANDY CUT TAPE	134	0002	SET LABELS ON MAIN BODY	550	0003	WEIMAN REMOVAL	270	0004	ASSEMBLE OUTER CASE	365	0005	FIT TOP PAD	268	0006	STICK LARGE-SIDE ORDER LABEL	117
0001	STICK HANDY CUT TAPE	134																			
0002	SET LABELS ON MAIN BODY	550																			
0003	WEIMAN REMOVAL	270																			
0004	ASSEMBLE OUTER CASE	365																			
0005	FIT TOP PAD	268																			
0006	STICK LARGE-SIDE ORDER LABEL	117																			

FIG. 69



**FIG. 70**

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## FIG. 71

### PARALLEL DIVISION

				▼	▲
PLAN 2		PLAN 1			
St 1		St 1			
1		1	STICK HANDY CUT TAPE	99	
2		2	SET LABELS ON MAIN BODY	78	
8		3	WEIMAN REMOVAL	134	
St 2		St 2			
3		4	ASSEMBLE OUTER CASE	732	
4		5	FIT TOP PAD	268	
5		6	STICK LARGE-SIDE ORDER LABEL	117	
			⋮		

FIG. 72

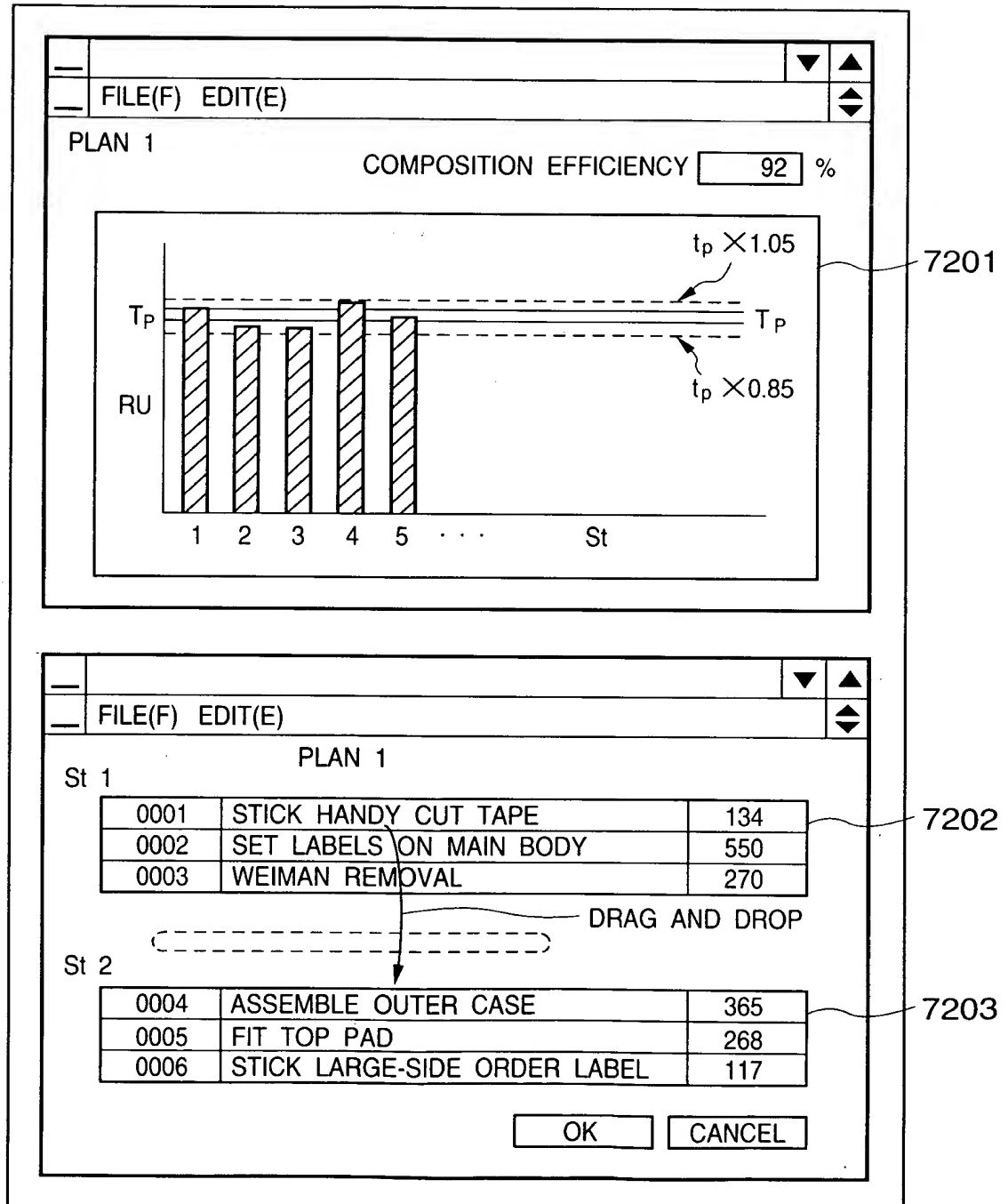
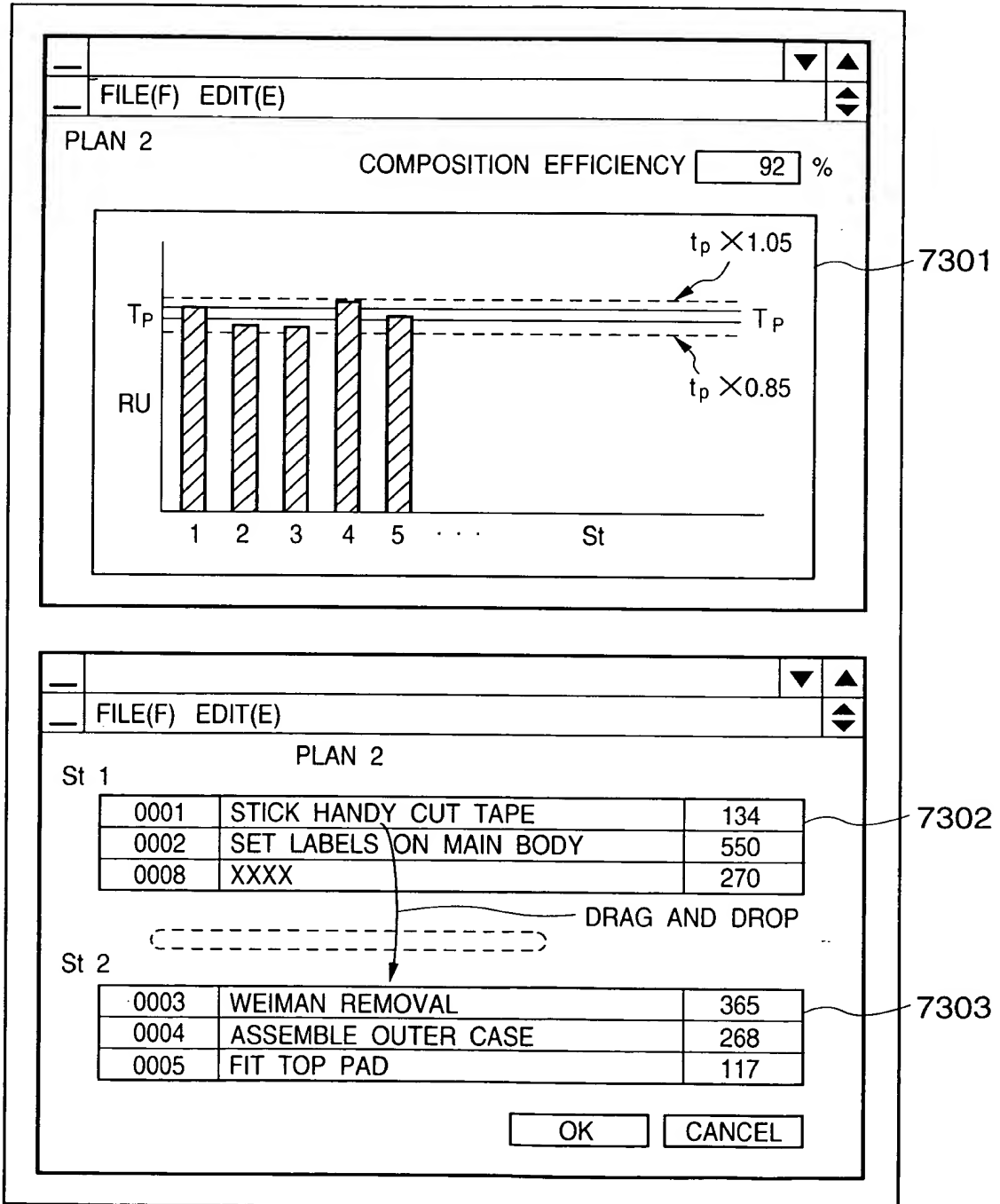




FIG. 73



**FIG. 74**

Figure 7 is a flowchart illustrating the process of loading newly composed data (manhourly). The process begins with a box labeled "LOAD OF NEWLY COMPOSED DATA (MANHOURLY)" (7403). This box contains two input fields: "GENRE" (7401) and "REPRESENTATIVE MODEL" (7404). The "REPRESENTATIVE MODEL" field points to a "TARGET MODEL" box (7405). The "TARGET MODEL" box points to a "COMPONENT" box (7406). The "COMPONENT" box contains a table with the following structure:

COMPONENT	SYMBOL	COMPONENT NAME	ORDER
BJ			
FAX			
LBP			
NP			
STAND			

The "COMPONENT" box points to a "CANCEL" box (7408). The "LOAD OF NEWLY COMPOSED DATA (MANHOURLY)" box also points to a "CANCEL" box (7408).

FIG. 75

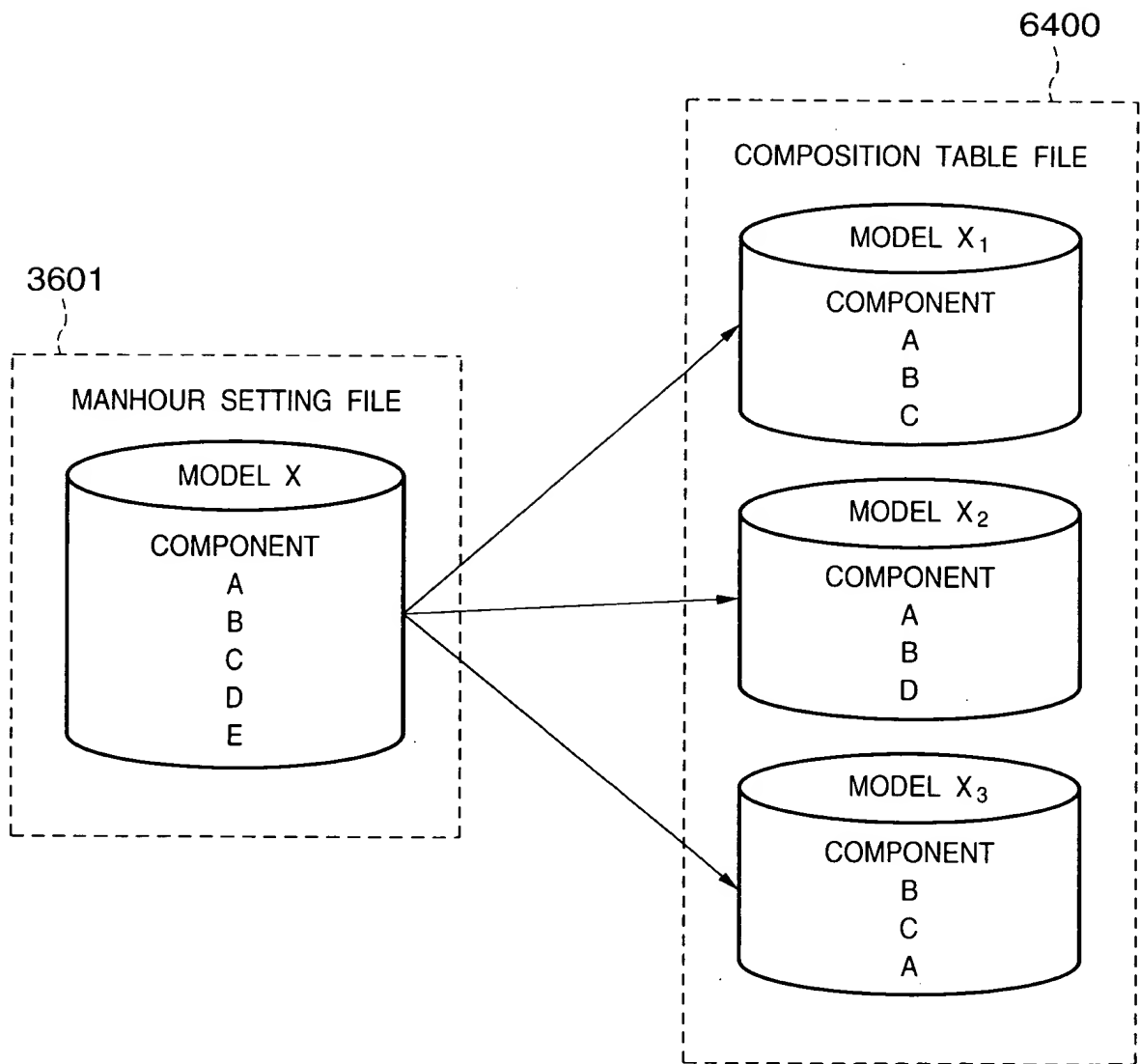


FIG. 76

7601

7602

7603

7604

OPEN FILE

TARGET MODEL

NAME

REVISION NUMBER

SAVE DATE

ファイル名	テストデータ(元)	テスト	1	97/09/19 12:00:34
f12-0010.csv			1	97/09/19 12:00:34
f12-0010.csv			0	97/09/19 13:27:17
BJC-4300		0	0	97/09/19 14:10:14
BJC-4300		0	0	97/09/19 14:10:32
			1	97/09/19 15:41:14

ファイル名	テストデータ(元)	テスト	1	97/09/19 12:00:34
BJC-4300	BJC-4300Aライン編成		03	97/10/13 17:54:57
BJC-4300	BJC-4300Aライン編成		00	97/09/20 14:06:36
BJC-4300	BJC-4300Aライン編成		05	97/09/24 17:11:53
f12-0010.csv	f12-0010Aライン編成			

SELECT WINDOW

○ COMPOSITION DATA INPUT WINDOW

○ COMPOSITOR DATA CORRECTION WINDOW

OK

CANCEL

7606

**FIG. 77**

[illegible]

**FIG. 78**

INSERTION OF UNIT WORK

NEW WORK WILL BE INSERTED BEFORE  
"STICK CHECK SHEET SERIAL NO."

INPUT WORK NAME AND PROVISIONAL MANHOUR VALUE

UNIT WORK NAME :

PROVISIONAL MANHOUR :  (RU)

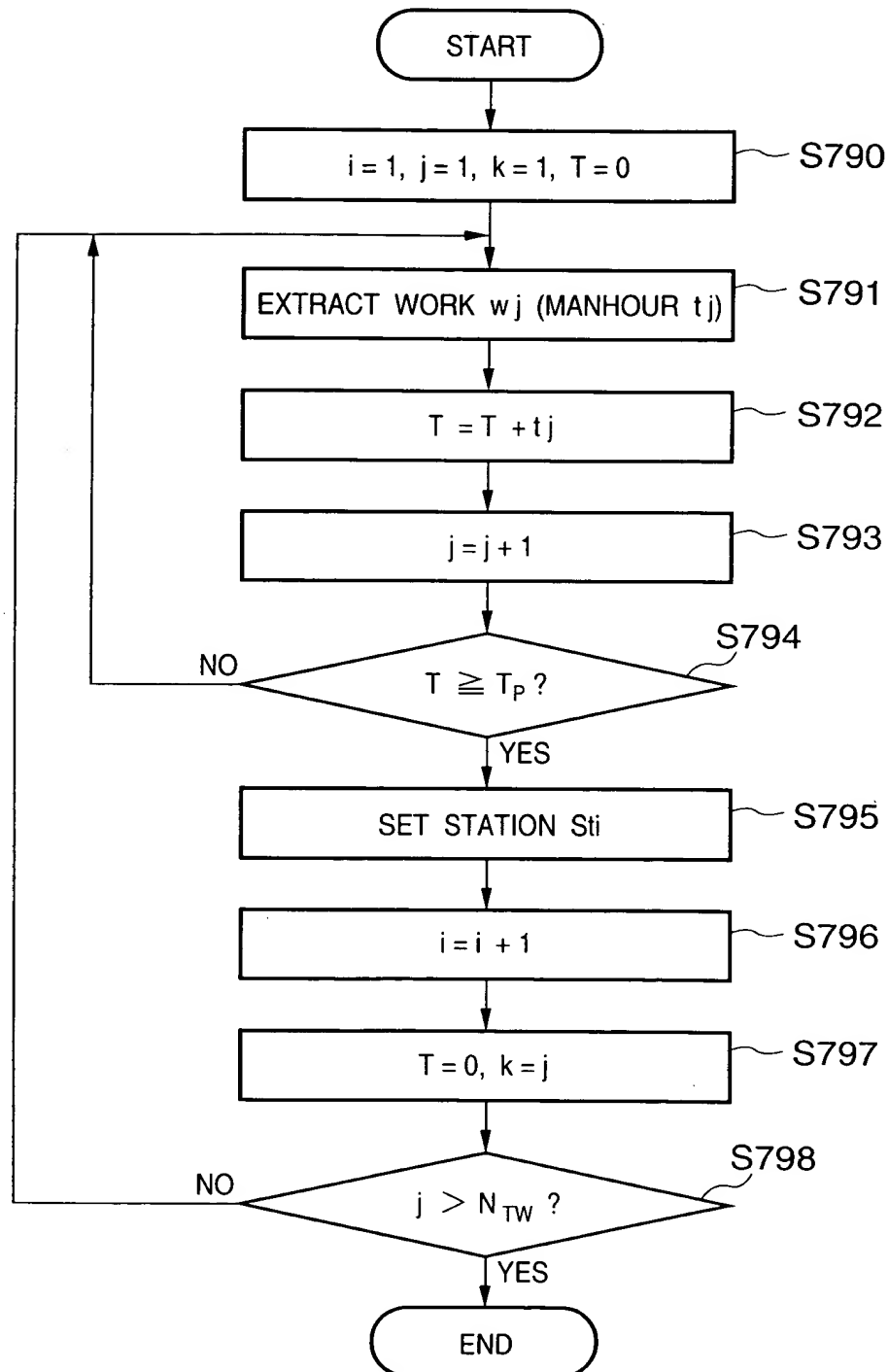
REMARKS :

OK CANCEL

7801

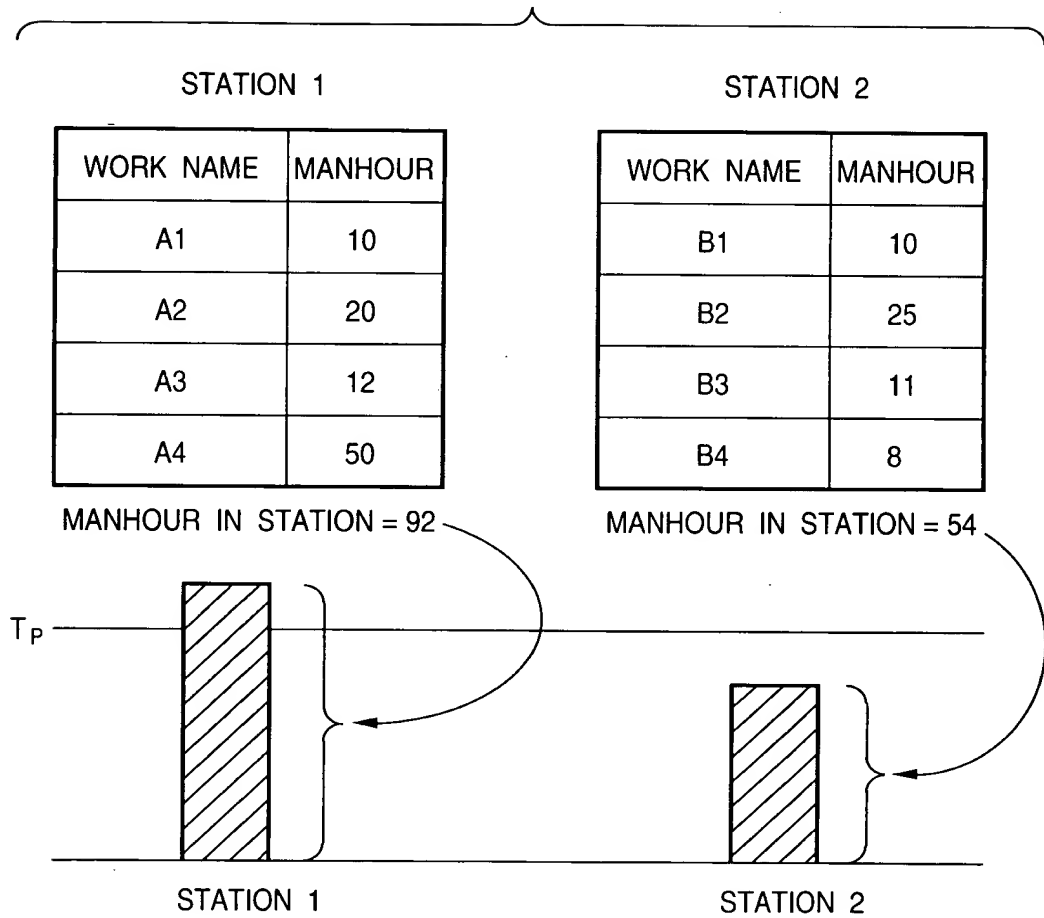
7802

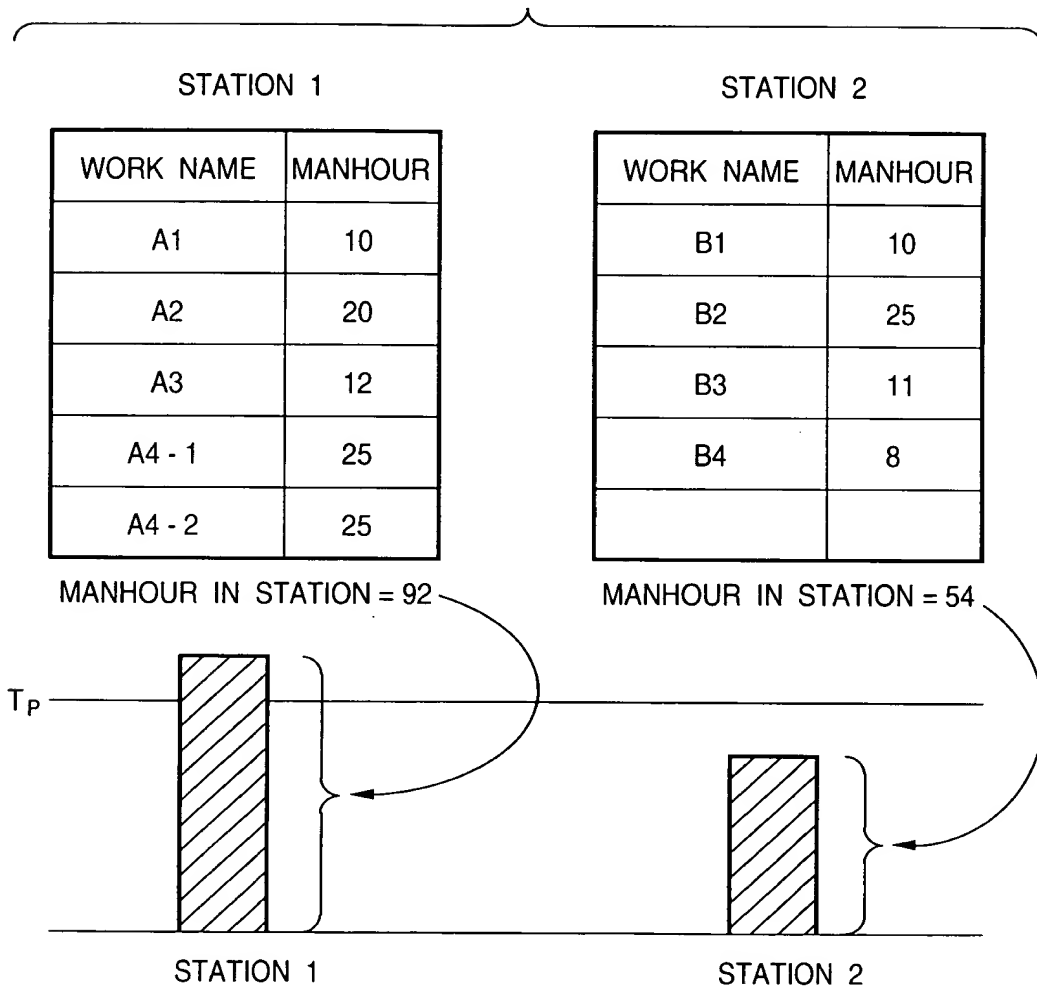
FIG. 79

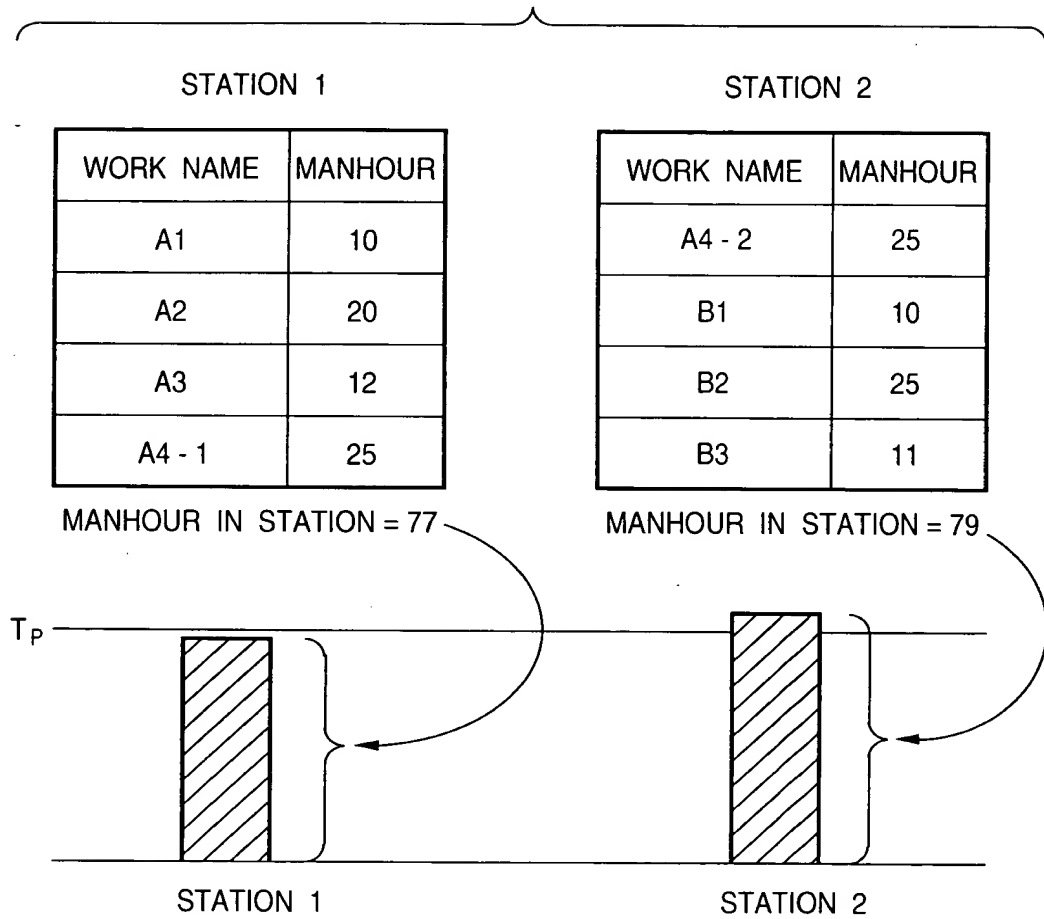






**FIG. 81**

**FIG. 82**

**FIG. 83**

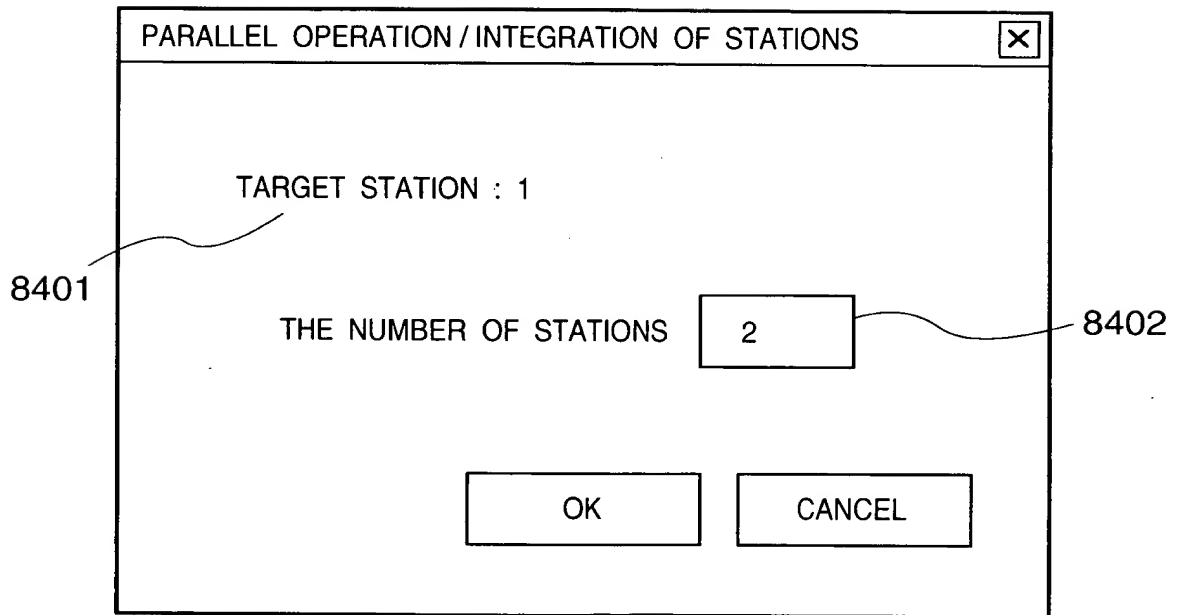
**FIG. 84**

FIG. 85

FILE(E) EDIT(E) VIEW(V) TOOL(T)

OPERATOR 1

S11

WORK NAME	WF	PROV. SIONAL MANHOUR	MA-CHINE UAL	MAN-UAL
START	0	0	No.	No.
UNIT WORK NAME 1	34	10	No.01	
UNIT WORK NAME 2	255	46	No.02	
UNIT WORK NAME 6	92	26	No.06	
UNIT WORK NAME 7	52	0	No.07	
UNIT WORK NAME 8	52	0	No.08	
UNIT WORK NAME 9	0	36	No.09	

TOTAL 585 (RU) PF 83.6%

OPERATOR 2

S12

WORK NAME	WF	PROV. SIONAL MANHOUR	MA-CHINE UAL	MAN-UAL
UNIT WORK NAME 3	156	0	No.03	
UNIT WORK NAME 4	34	0	No.04	
UNIT WORK NAME 5	138	23	No.06	
UNIT WORK NAME 10	71	48	No.10	
UNIT WORK NAME 11	138	30	No.11	
UNIT WORK NAME 12	97	20	No.12	
UNIT WORK NAME 13	88	0	No.14	
UNIT WORK NAME 14	46	18	No.15	
UNIT WORK NAME 15	546	15	No.16	
UNIT WORK NAME 17	58	20	No.17	

TOTAL 1548 (RU) xxxxxx PF 23.5 %

OPERATOR 3

S13

WORK NAME	WF	PROV. SIONAL MANHOUR	MA-CHINE UAL	MAN-UAL
UNIT WORK NAME 13	30	40	No.13	
UNIT WORK NAME 16	303	131	No.18	

TOTAL 572 (RU) PF 96.7%

OPERATOR 4

S14

WORK NAME	WF	PROV. SIONAL MANHOUR	MA-CHINE UAL	MAN-UAL
UNIT WORK NAME 19	84	26	No.19	
UNIT WORK NAME 20	120	20	No.20	
UNIT WORK NAME 21	310	66	No.21	

TOTAL 623 (RU) PF 95.2%

OPERATOR 5

S15

WORK NAME	WF	PROV. SIONAL MANHOUR	MA-CHINE UAL	MAN-UAL
UNIT WORK NAME 22	146	71	No.22	
UNIT WORK NAME 23	106	26	No.23	
UNIT WORK NAME 24	61	0	No.24	
UNIT WORK NAME 25	51	10	No.25	
END	0	0	No.X	

TOTAL 486 (RU) PF 73.6%

PARALLEL STATIONS

900  
720  
540  
360  
180  
0

1 2 3 4 5

G STANDARD NO. WORK NAME

WF MEANS MA-CHINE MANHOUR

PROVISIONAL REMARKS

COMPOSITION EFFICIENCY 116 %

NET COMPOSITION EFFICIENCY %

COMPOSITION MODE : PRIORITY ORDER SCHEME

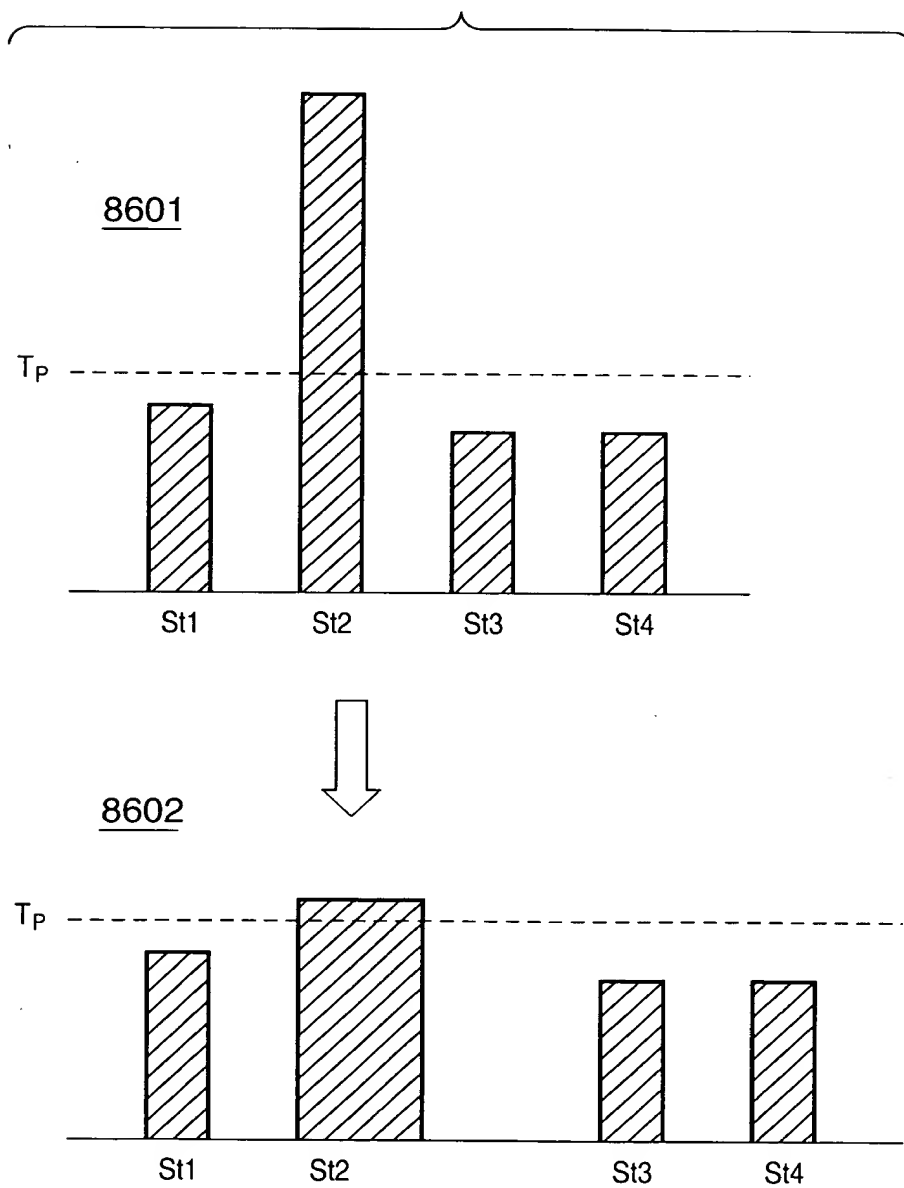
**FIG. 86**

FIG. 87

A screenshot of a 'USER REGISTRATION' dialog box. The dialog has a title bar with a close button (X). Inside, there are five input fields with labels to their left: 'NAME CODE :', 'NAME :', 'POSITION :', 'PASSWORD :', and 'AUTHORITY :'. The 'NAME CODE' field contains '12345'. The 'NAME' field is split into two boxes containing '田中' and '一郎'. The 'POSITION' field contains 'kumitate' and has a dropdown arrow on the right. The 'PASSWORD' field contains '12345'. The 'AUTHORITY' field is empty. At the bottom are 'OK' and 'CANCEL' buttons. On the right side, five callout numbers (8701-8705) are connected by lines to specific parts of the form: 8701 points to the 'NAME CODE' field, 8702 points to the first part of the 'NAME' field ('田中'), 8703 points to the second part of the 'NAME' field ('一郎'), 8704 points to the 'PASSWORD' field, and 8705 points to the 'AUTHORITY' field.

USER REGISTRATION

NAME CODE : 12345 8701

NAME : 田中 一郎 8702

POSITION : kumitate 8703

PASSWORD : 12345 8704

AUTHORITY : 8705

OK CANCEL

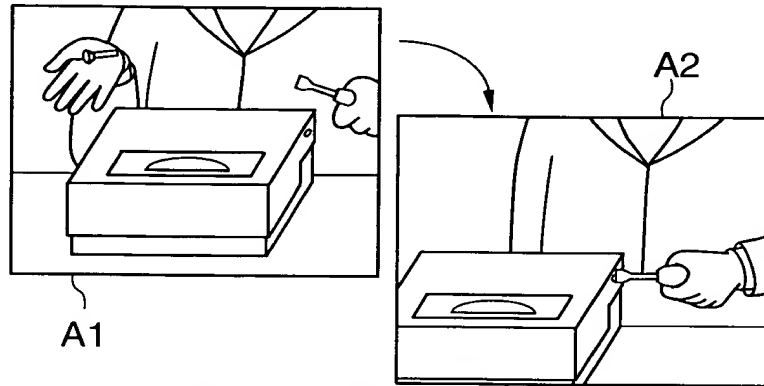
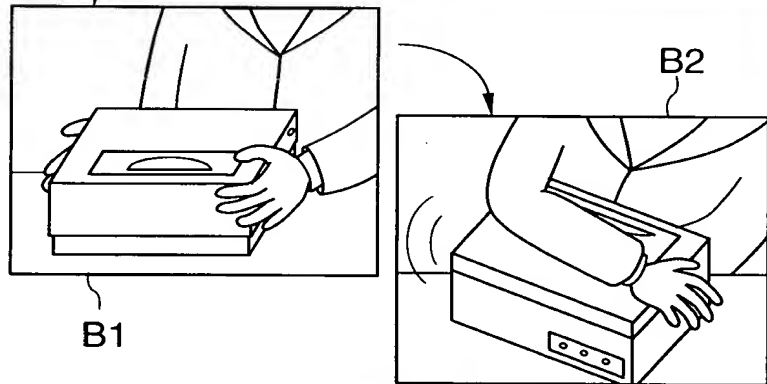
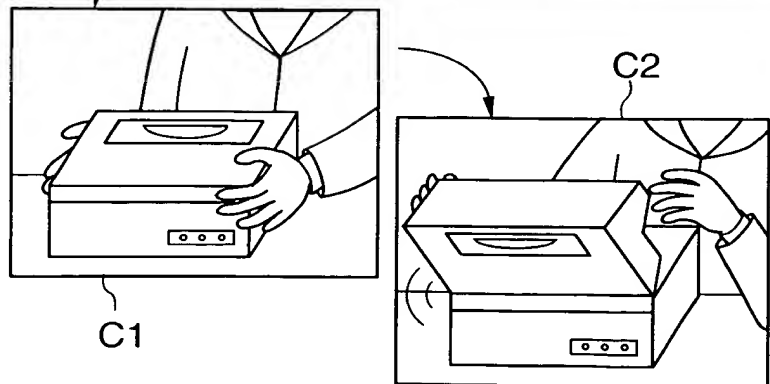
MERGE





FIG. 89

DIRECTORY NAME	IMAGE DATA	OPERATION (VERB)	PARAMETER 1	PARAMETER 2	PARAMETER 3
xxxxx1	SCREW	SCREW	SCREW CLOCKWISE	DISTANCE MOVEMENT 10mm	TORQUE 10Kg.M
xxxxxx2	SCREW	SCREW	SCREW CLOCKWISE	DISTANCE MOVEMENT 20mm	TORQUE 20Kg.M
xxxxxx3	SCREW	SCREW	SCREW CLOCKWISE	DISTANCE MOVEMENT 20mm	TORQUE 30Kg.M
...	...	...	...	...	...
yyyyyy1	ROTATE	ROTATE	CLOCKWISE	DISTANCE MOVEMENT 20mm	
yyyyyy2	ROTATE	ROTATE	COUNTERCLOCKWISE	DISTANCE MOVEMENT 20mm	
...	...	...	...	...	...
zzzzzz1	OPEN	OPEN	OPEN UPWARD	DISTANCE MOVEMENT 30mm	WEIGHT 100g
zzzzzz2	OPEN	OPEN	OPEN DOWNWARD	DISTANCE MOVEMENT 40mm	WEIGHT 200g
...	...	...	...	...	...

**FIG. 90****1. SCREW A****2. ROTATE MAIN BODY****3. OPEN COVER**

**FIG. 91**

9101 9102

SETTING OF COMPONENT SYMBOL

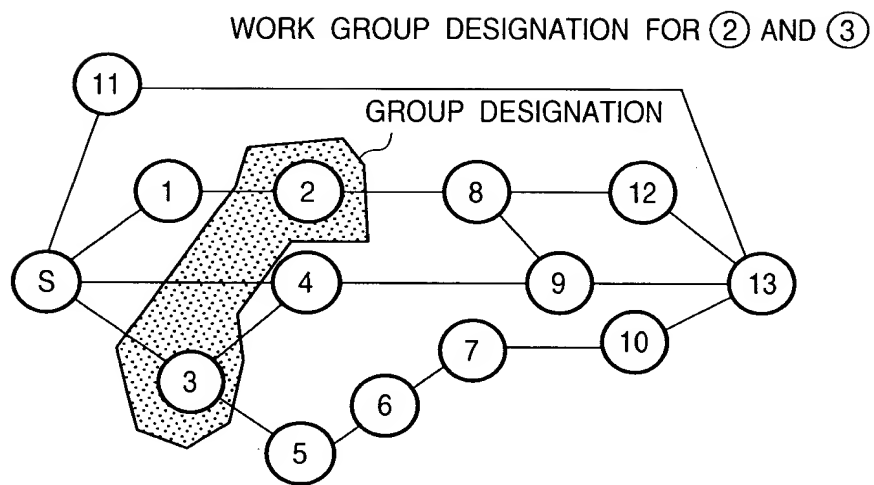
PRODUCT SYMBOL : BJ - 970909

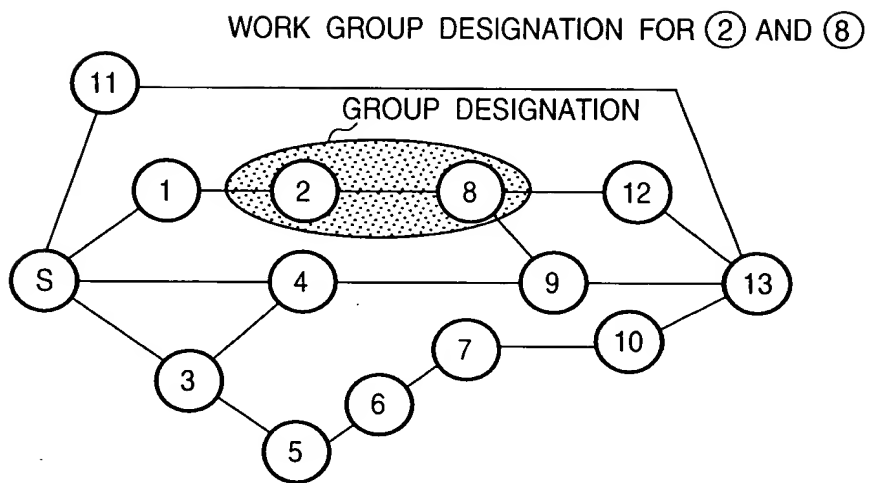
COMPONENT SYMBOL : CH

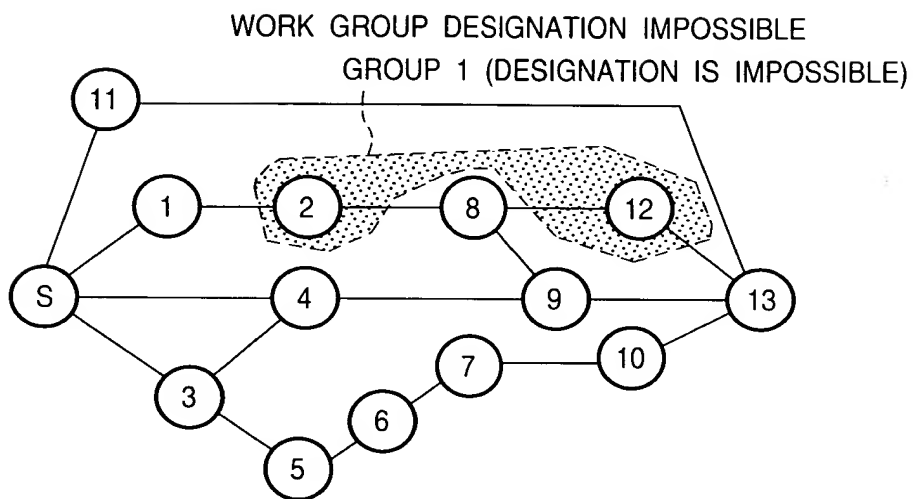
COMPONENT NAME : CHECK

OK SEARCH COMPONENT CANCEL

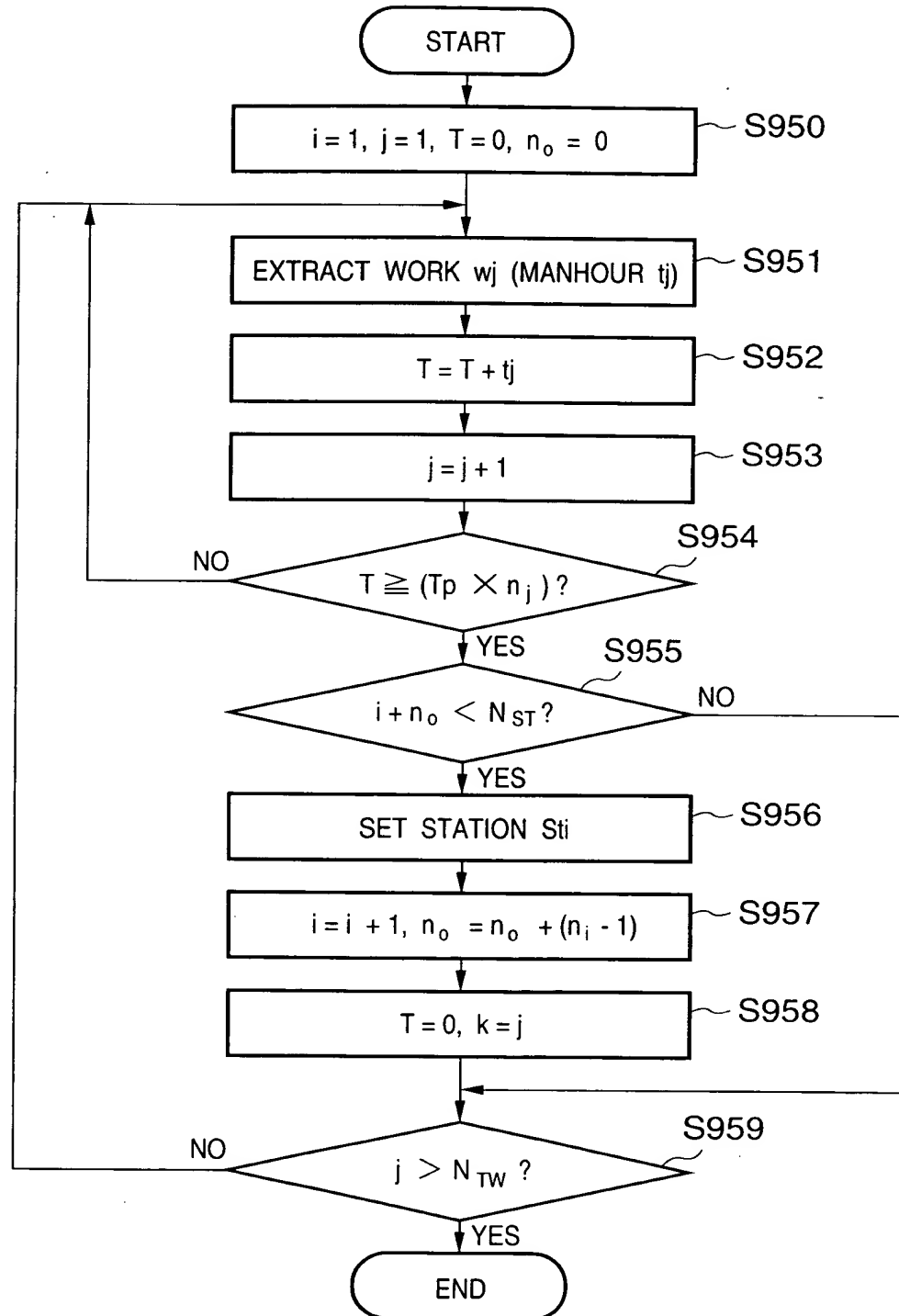
**FIG. 92**



**FIG. 93**

**FIG. 94**

## FIG. 95



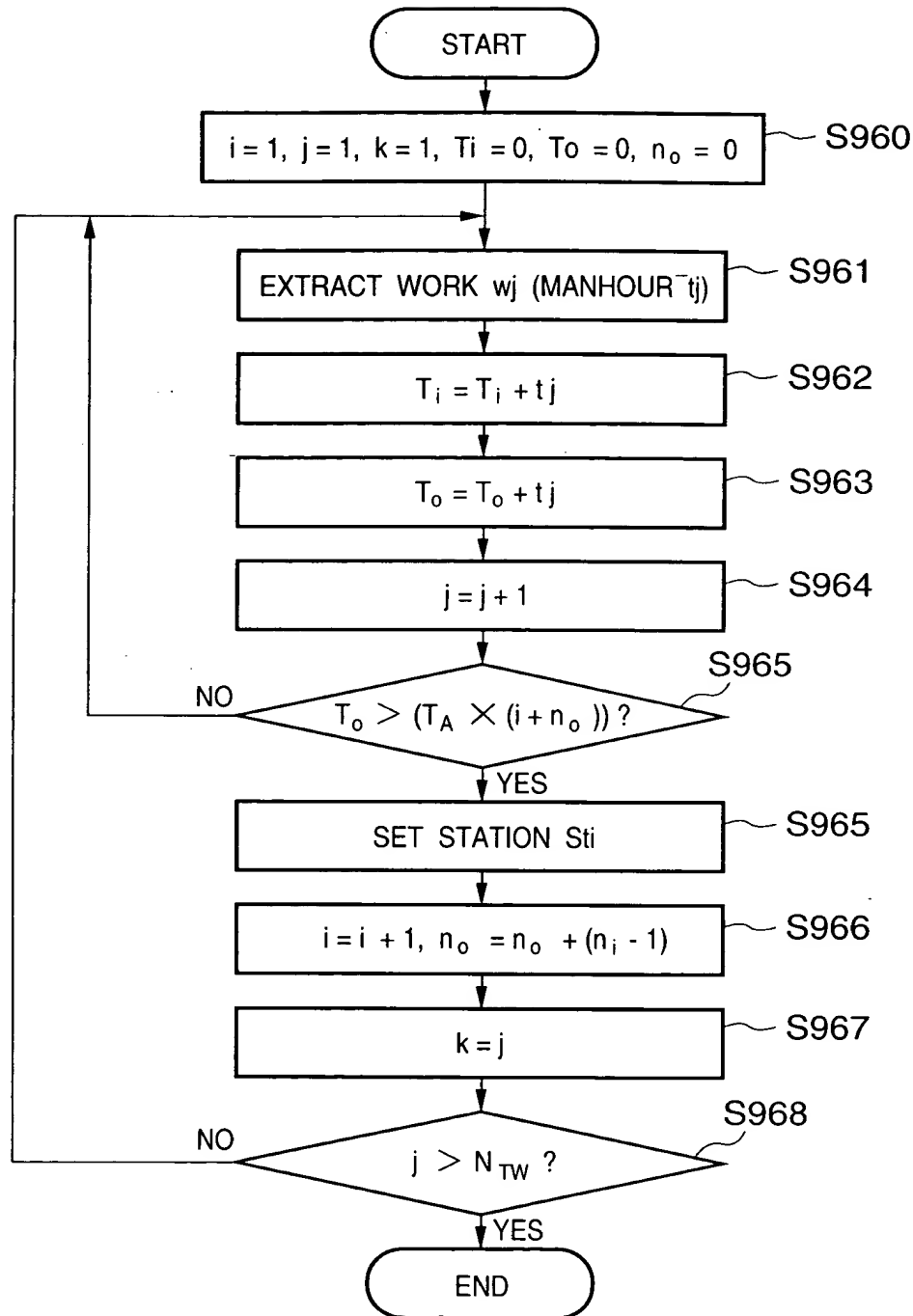
$N_{ST}$ : THE NUMBER OF STATIONS

$n_i$  :  $i$  STATION PARALLEL NUMBER

$n_o$  : TOTAL ACCUMULATED PARALLEL SUM NUMBER

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# FIG. 96



$N_{ST}$ : THE NUMBER OF STATIONS

$T_i$ :  $i$  STATION MANHOUR

$T_A$ : STATION MANHOUR AVERAGE VALUE

$$T_A = WF / N_{ST}$$

$T_o$ : TOTAL ACCUMULATED MANHOUR

$n_i$ :  $i$  STATION PARALLEL NUMBER

$n_o$ : TOTAL ACCUMULATED PARALLEL SUM NUMBER



# FIG. 97

FILE(E) EDIT(E) VIEW(D) TOOL(T)

OPERATOR 1

S1

WORK NAME	WF	PROV- SIONAL MAN-CHINE UAL	MAN-CHINE UAL
START	0	0	No.
UNIT WORK NAME 1	34	10	No.01
UNIT WORK NAME 2	255	46	No.02
UNIT WORK NAME 6	92	26	No.06
UNIT WORK NAME 7	52	0	No.07
UNIT WORK NAME 8	52	0	No.08
UNIT WORK NAME 9	0	36	No.09

TOTAL 585 (RU)

OPERATOR 2

S2

WORK NAME	WF	PROV- SIONAL MAN-CHINE UAL	MAN-CHINE UAL
UNIT WORK NAME 3	156	0	No.03
UNIT WORK NAME 4	34	0	No.04
UNIT WORK NAME 5	138	23	No.08
UNIT WORK NAME 10	71	48	No.10
UNIT WORK NAME 11	138	30	No.11
UNIT WORK NAME 12	97	20	No.12
UNIT WORK NAME 13	88	0	No.14
UNIT WORK NAME 14	46	18	No.15
UNIT WORK NAME 15	546	15	No.16
UNIT WORK NAME 17	58	20	No.17

TOTAL 1548 (RU) xxxxxxx

OPERATOR 3

S3

WORK NAME	WF	PROV- SIONAL MAN-CHINE UAL	MAN-CHINE UAL
UNIT WORK NAME 13	30	40	No.13
UNIT WORK NAME 16	303	131	No.18

TOTAL 572 (RU)

OPERATOR 4

S4

WORK NAME	WF	PROV- SIONAL MAN-CHINE UAL	MAN-CHINE UAL
UNIT WORK NAME 19	84	26	No.19
UNIT WORK NAME 20	120	20	No.20
UNIT WORK NAME 21	310	66	No.21

TOTAL 6238 (RU)

OPERATOR 5

S5

WORK NAME	WF	PROV- SIONAL MAN-CHINE UAL	MAN-CHINE UAL
UNIT WORK NAME 22	146	71	No.22
UNIT WORK NAME 23	106	26	No.23
UNIT WORK NAME 24	61	0	No.24
UNIT WORK NAME 25	51	10	No.25
END	0	0	No.X

TOTAL 486 (RU)

OPERATOR 6

S6

WORK NAME	WF	PROV- SIONAL MAN-CHINE UAL	MAN-CHINE UAL
UNIT WORK NAME 22	146	71	No.22
UNIT WORK NAME 23	106	26	No.23
UNIT WORK NAME 24	61	0	No.24
UNIT WORK NAME 25	51	10	No.25
END	0	0	No.X

TOTAL 486 (RU)

PF 83.6% PARALLEL STATIONS PF 117.3% PARALLEL STATIONS

PF 95.2% PF 96.7% PF 73.6%

G STANDARD NO. WORK NAME

1 2 3 4 5

900 720 540 360 180 0

--- tp

--- tp\*1.05

--- tp\*0.85

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COMPOSITION MODE : PRIORITY ORDER SCHEME

COMPOSITION EFFICIENCY 96.43 %

NET COMPOSITION EFFICIENCY %